OWNER'S MANUAL
MODULAR KETTLES

MODELS:

MT-5	MT5-5E
	MT5-T56
MT-25	M-10
MT-40	M-25
MT-60	M-40
	M-60
M25X	M40X

COVERING:
- INSTALLATION
- OPERATION
- MAINTENANCE
- SERVICE & PARTS

MARKET FORGE INDUSTRIES INC.
An Employee Owned Company

Form No. S-2110 08/03
Printed in U.S.A.

35 Garvey Street | Everett | MA | 02149
Tel: (617) 387-4100 | Fax: (617) 387-4456 | (Outside MA) 1 (800) 227-2659
Website: www.mfii.com | E-Mail: CUSTSERV@mfii.com

TABLE OF CONTENTS

Paragraph *Page*

SECTION 1 INTRODUCTION
1.1 Description 1-1
1.1.1 5 Gallon Tilting Kettle 1-1
1.1.2 10-, 25-, 40- & 60- Gallon Stationary Kettles 1-1
1.1.3 25-, 40- & 60- Gallon Tilting Kettles 1-1
1.1.4 25- & 60- Gallon Chill Kettles 1-2
1.2 Service 1-2

SECTION 2 operation
2.1 Operating Controls & Indicators 2-1
2.2 Operating Procedure - 5 Gallon Tilting Kettle 2-1
2.3 Operating Procedure - 10-, 25-, 40- & 60- Gallon Kettles 2-1
2.4 Cleaning Procedure 2-3
2.4.1 Cleaning 5 Gallon Tilting Kettles 2-3
2.4.2 Cleaning 10-, 25- & 40- Gallon Kettles 2-3
2.5 Pan Support Mounting 2-3

Paragraph *Page*

SECTION 3 maintenance
3.1 General 3-1
3.2 Preventive Maintenance 3-1
3.2.1 Cleaning 3-1
3.2.2 Tilting Mechanism 3-1
3.3 Repair & Replacement 3-1
3.3.1 Lid Counterbalance Adjustment 3-1
3.3.2 Cabinet Exterior Removal 3-2
3.3.3 5 Gallon Trunnion Mounted Kettle Disassembly 3-2
3.3.4 Draw-Off Valve Repair 3-2
3.3.5 Tilting Mechanism Repair 3-2

SECTION 4 illustrated parts list
4.1 General 4-1
4.2 Ordering Information 4-1
4.3 Index of ILLUSTRATED PARTS LIST 4-1
APPENDIX A-1

list of illustrations

Figure *Page*

SECTION 2 operation
2-1 Mounting Pan Support 2-4

SECTION 3 maintenance
3-1 Lid Counterbalance Adjustment 3-1
3-2 Ball Nut Assembly 3-3

SECTION 4 illustrated parts list
4-1 5 Gallon Tilting Kettle 4-2
4-2 Trunnion Pedestal 4-3
4-3 Faucet, 5 Gallon Tilting Kettle 4-4
4-4 10-, 25- & 40- Gallon Stationary Kettle 4-5
4-5 60- Gallon Stationary Kettle 4-6
4-6 25- & 40- Gallon Tilting Kettle 4-7
4-7 Tilting Mechanism 25- & 40- Gallon Kettle 4-8

Figure *Page*

4-8 60- Gallon Tilting Kettle 4-9
4-9 Tilting Mechanism 60- Gallon Kettle 4-10
4-10 25- & 40- Gallon Chill Kettle 4-11
4-11 Hinge & Lid Assembly 4-12
4-12 Steam Supply Valve 4-13
4-13 Swing Dran 4-13
4-14 Draw-Off Valve 4-14
4-15 Steam-Trap 4-14
4-16 Faucet & Spout Assembly 4-15
4-17 18" Cabinet 4-16
4-18 24" Cabinet 4-17
4-19 36" Cabinet 4-18
4-20 48" Cabinet 4-19
4-21 12" Spacer with Sink & Faucet 4-20
4-22 Accessories for Steam Jacketed Kettles 4-21

list of TABLES

Table *Page*

SECTION 2 operation
2-1 Operating Controls, 5 Gallon Kettle 2-2
2-2 Operating Controls, 10-, 25-, 40- &60- Gallon Kettle 2-2

Form No. S-2110 08/03
Printed in U.S.A.

SECTION 1 INTRODUCTION

This service and parts manual contains general information, operation, and maintenance information for Market Forge modular kettles. A parts list is included in which each replaceable part is identified and shown in an accompanying drawing. Accessories for use with the kettles are also described.

1.1 DESCRIPTION

Market Forge Kettles include both stationary and tilting steam jacketed kettles of five capacities, each mounted in a modular stainless steel cabinet.

Double wall construction around the lower half of the kettle forms a surrounding chamber into which steam is introduced as a source of heat for cooking.

Steam input plumbing is equipped with a manual control valve. Condensate is removed through a steam trap connecting with the kettle drain plumbing assembly. A swivel spout, hot-cold combination faucet provides a source of water for addition to the kettle for cooking and cleaning.

An optional 12" spacer unit with faucet and sink may be used instead of the standard built-in faucet.

1.1.1 5 Gallon Tilting Kettle

The 5-gallon 191itre capacity kettle is mounted in a trunnion assembly to the modular cabinet top. The trunnion pivots include steam input and return connections for the kettle.

A sink equipped with re- versible splash shield is built into the cabinet top under the kettle pouring spout. Kettle tilting is accomplished manually by moving a handle fixed to the rim so as to rotate the kettle in a trunnion mount.

Applicable model designation include:

MT-5 A single kettle mounted on an 18" *457mm* wide cabinet base equipped for direct connection to a remote steam source.

MT5-T5 Two kettles mounted side-by-side on a 36" *914mm* wide cabinet base equipped for direct connection to a remote steam source.

1.1.2 10-,25-,40-, & 60-Gallon Stationary Kettles

These units include large capacity kettles mounted in fixed position in modular cabinet bases. A counter-balanced, hinged lid covers the kettle openings.

Each is plumbed for direct connection to a remote steam source. An optional cold water circuit to the steam jacket is available for use with all models for quick cooling of foods after cooking. See paragraph 1.1.4.

Applicable model designation include:

M-10 A 10-gallon 37 litre capacity stationary kettle mounted in a 24" 609 mm wide cabinet base.

M-25 A 25-gallon 95 litre capacity stationary kettle mounted in a 36" 914 mm wide cabinet base.

M-40 A 4O-gallon 152 litre capacity stationary kettle mounted in a 36" 914 mm wide cabinet base.

M-60 A 60-gallon 228 litre capacity stationary kettle mounted in a 36" 914 mm wide cabinet base.

1.1.3 25-, 40-, & 60-Gallon Tilting Kettles

Large capacity kettles are fitted with heavy duty tilting mechanisms operated bya removable hand crank. Each model is equipped with a pan support which maintains continuous alignment of serving pans under the pouring spout at all levels of kettle elevation.

Counterbalanced hinged lids cover the kettles in the lowered position. All are plumbed for direct connection to a remote steam source. An optional cold water circuit to the steam jacket is available for use with all models for quick cooling of foods after cooking. See paragraph 1.1.4.

Form No. S-2110 08/03
Printed in U.S.A.

SECTION 1 INTRODUCTION

Applicable model designations include:

MT-25 A 25-gallon 94 litre capacity tilting kettle mounted in a 36" *914mm* wide cabinet base.

MT-40 A 40-gallon 152 litre capacity tilting kettle mounted in a 36" *914mm* wide cabinet base.

MT-60 A 60-gallon 228 litre capacity tilting kettle mounted in a 48" *1219mm* wide cabinet base.

1.1.4 25- & 40-Gallon Chill Kettles

The chill kettle is a modified application of the stationary models equipped with a built-in sink completely surrounding the kettle. The kettle functions to instantly suspend cooking by allowing kettle interior to be flooded with cold water. Hot cooking water rises over the rim and into the sink.

A further modification is the addition of a jacket cooling system consisting of a cold water plumbing assembly connected to the kettle jacket. The system is used in conjunction with kettle flooding to rapidly cool the kettle by allowing cold water to fill the steam jacket.

Applicable model designations include:

M25X A 25-gallon 95 litre capacity stationary kettle mounted in a 36" *914mm* wide cabinet with overflow sink and jacket cooling system.

M40X A 40-gallon 152 litre capacity stationary kettle mounted in a 36" *914mm* wide cabinet with overflow sink and jacket cooling system.

1.2 SERVICE

Modular kettles are exceptionally reliable and durable cooking equipment requiring a minimum of service other than routine cleaning and preventive methods explained in Section 3. Should repairs be required, a network of authorized service agencies is available to a,ssist with prompt service.

A current Directory of Authorized Service Agencies may be obtained by contacting:

Customer Service Department, Market Forge
35 Garvey Street, Everett, Massachusetts 02149
Telephone: (617) 387-41 00

Customer Service Department, Market Forge
Canada, Ltd.
1375 Aimco Blvd., Unit 5
Mississauga, Ontario, Canada
Telephone: (416) 621-9252

The model and serial numbers must be referenced when corresponding with Market Forge.

The data plate containing model and serial numbers pertaining to the equipment is locatedinside the cabinet door on the right vertical frame member.

SECTION 2 Operation

2.1 OPERATING CONTROLS & INDICATORS

All of the controls required to operate the kettles are listed in Tables 2-1 and 2-2, together with an explanation of location and a short functional description.

2.2 OPERATING PROCEDURE 5 GALLON TILTING KETTLE

All 5 gallon kettles must be supplied with steam from a generator which may be remotely located or built into the same cabinet base on which the kettle is mounted. Consult steam generator information or instruction plate and complete all start-up instructions. Proceed with kettle operating procedure as follows:

1. Check pressure gauge of steam supply source to insure steam input is at 15 PSI *1.0 kg/cm²*. For direct connected steam, turn on external steam supply valve.

2. Load kettle with foods to be cooked.

3. Add water for cooking by turning Swivel Spout over kettle and using Combination Faucet.

4. Turn Steam Control Valve to full counter- clockwise position to heat kettle content to an initial rapid boil.

5. Adjust subsequent cooking temperature by turning Steam Control Valve. Turn clock-wise to reduce heat and counter-clockwise to increase.

6. Close Steam Control Valve and remove food from kettle as soon as cooking is complete to prevent over-cooking. With Splash Shield in the rear, place food pan on sink grate and tip kettle forward using the Kettle Handle.
   NOTE: Swivel Spout must be rotated clear of kettle before tilting.

7. Complete cleaning procedure (see paragraph 2.4.1).

2.3 OPERATING PROCEDURE- 10- 25- 40- & 60 GALLON KETTLES

All kettles must be supplied with steam from a generator which is remotely located. Consult steam generator information or instruction plate and complete all start-up instructions. Proceed with kettle operating procedure as follows:

1. Check pressure gauge of steam supply source to insure steam input is at 15 PSI *1.0 kg/cm²*. For direct connected steam, turn on external steam supply valve.

2. Check that Draw-Off Valve is tightly closed.

3. Lift kettle lid and place either a Solid or Perforated Drain Disc over the drain inside kettle. Use solid disc to retain liquids; perforated to strain liquids from food.

4. Load kettle with foods to be cooked.

5. Add water for cooking by swinging spout over kettle and using Combination Faucet.

6. Turn Steam Control Valve to full counter-clockwise position to heat kettle content to an initial rapid boil.

7. Adjust subsequent cooking temperature by turning Steam Control Valve. Turn clockwise to reduce heat and counter-clockwise to increase.

8. Close Steam Control Valve (full clockwise position) when cooking is complete.
   CAUTION: Food must either be removed from the kettle immediately or cooled by a kettle jacket cooling system to prevent over cooking.

9. For Chill Kettles use an external water source to flood kettle interior with cold water until all hot cooking water flow over kettle rim into sink.

Table 2-1
Operating Controls - 5 Gallon Kettle

NAME	loaction	Function
Kettle Handle	Kettle Rim	Grasped to Tilt Kettle for Pouring.
Steam Control Valve	Top, Left Side	Controls Steam Folw to Kettle Jacket.
Combination Faucet	Top, Right Side	Controls Hot & Cold Water to Swivel Spout.
Swivel Spout	Top, Beside Kettle	Direct Water into Kettle. Turns away for Kettle Tilting.
Sink wuth Splash Shield	Top, Front	Accepts Kettle Drainage. Sheld Forward Protects Operator from Splashing - Reverses for Stowage.

Table 2-2
Operating Controls - 5 Gallon Kettle

NAME	loaction	Function
Lid Handle	On Lid	Grasped to open & close Kettle Lid.
Perforated Drain Disc	Inside Kettle on Drain	Covers drain to strain liquids when draw-off is opened.
Solid Drain Disc (Optional)	Inside Kettle on Drain	Covers drain to block it off.
Crank (Tilitng Kettles)	Front, Right Side	Raises & Lowers Tilting Kettles for pouring. Stowa on Back of cabinet door when not in use.
Steam Control Valve	Top, Right Side	Controls Steam flow to Kettle Jacket.
Draw-Off Valve	Inside Cabinet, Left	Controls drainage of Kettle.
Swing Drain with Strainer	Inside Cabinet, Left	Accepts drainage from draw-off valve. Swings to side to allow serving containers to be placed under draw-off valve.
Combination Faucet with Swivel Spout	Top, Right Side	Controld hot & cold water to Kettle interior. Turns away for kettle tilting & access.
Cold Water Valve (Chill Kettles & others with Optional Jacket Cooling System)	Right, Front	Controls flow of water to steam jacket for rapid cooling after cooking.
Basin Waste Drain (Chill Kettles Only)	Left, Top	Accepts kettle overflow in chill kettle sink.
Pan Support (Tilting Kettles Only)	Front, Top	Holds serving pan in alignment with kettles for pouring. (See Subsection 2.5)

Form No. S-2110 08/03
Printed in U.S.A.

water jacket cooling system open the Jacket Cold Water Valve (full counter-clockwise position) and leave open until food temperature is sufficiently lowered.

11. Remove food from stationary kettles. For liquids rotate the Swing Drain to the side and fill food containers from the Draw-Off Valve. For solids which will not pass through the valve, use a ladle. An optional stationary pan holder (Part No. 90-3427) can be used to support pan during filling.

12. Remove food from tilting kettles. With Pan Support mounted (see subsection 2.5), food pan in support, and Crank installed in front of cabinet, turn crank clockwise to elevate kettle for pouring. (Tilting mechanism is infinitely adjustable and non-coasting in kettle elevation and lowering). Liquid foods may also be removed by use of the Draw-Off Valve as explained in step 11 for stationary kettles.

13. Complete cleaning procedures (See paragraph 2.4.2).

2.4 CLEANING PROCEDURE

As with cleaning food soil from any cookware, an important part of kettle cleaning is to prevent foods from drying on. For this reason cleaning should be completed immediately after cooked foods are removed. If time can not be allotted for immediate complete cleaning the kettle should be soaked by filling it with warm detergent water solution.

2.4.1 Cleaning 5 Gallon Tilting Kettle

1. Wash the kettle with a nylon bristle kettle brush (Part No. 10-5309).

2. Place Splash Shield in Sink with shield in front and tilt kettle to pour out wash water .

3. Rinse kettle by returning it to the upright position, flush with hot water from the Swivel Spout and empty.

4. Wash Splash Shield and replace in Sink.

2.4.2 Cleaning 10-, 25-, 40- & 60-Gallon Kettles

1. Wash the kettle with a long handled nylon bristle kettle brush (Part No. 10-5308).

2. Empty wash water by opening Draw-Off Valve over Swing Drain.

3. Remove Drain Disc (solid or perforated) from inside kettle and clean.

4. Rinse kettle by flushing with hot water from the Swivel Spout.

5. Loosen hex nut on Draw-Off Valve and carefully remove all parts. Clean and reassemble. (See figure 4-14).

6. Rotate Swing Drain to left and push up off drain assembly. Clean drain and screen. Reassemble on kettle.

2.5 Pan Support Mounting -Tilting Kettles

For convenience during cooking, the pan support need not be installed until needed for removing food from the kettles. To Insure correct operation and to prevent spills the support must be securely installed as shown in Figure 2-1 and as explained below:

1. Hold the pan support in front of the upright as shown at A.

2. Place the stud of the left-hand support upright into the hole in the left side of the pan support. Then push the right side of the support in until it engages the spring-loaded pin of the right-hand support upright, shown at B.

3. Rotate the pan support upward (C) and engage the slotted ends of the support links in the studs at the base of eact support upright as in D.

The removal procedure is the reverse of instaliation with the exception that in step 2 support upright springs must be pushed out to release the support from studs.

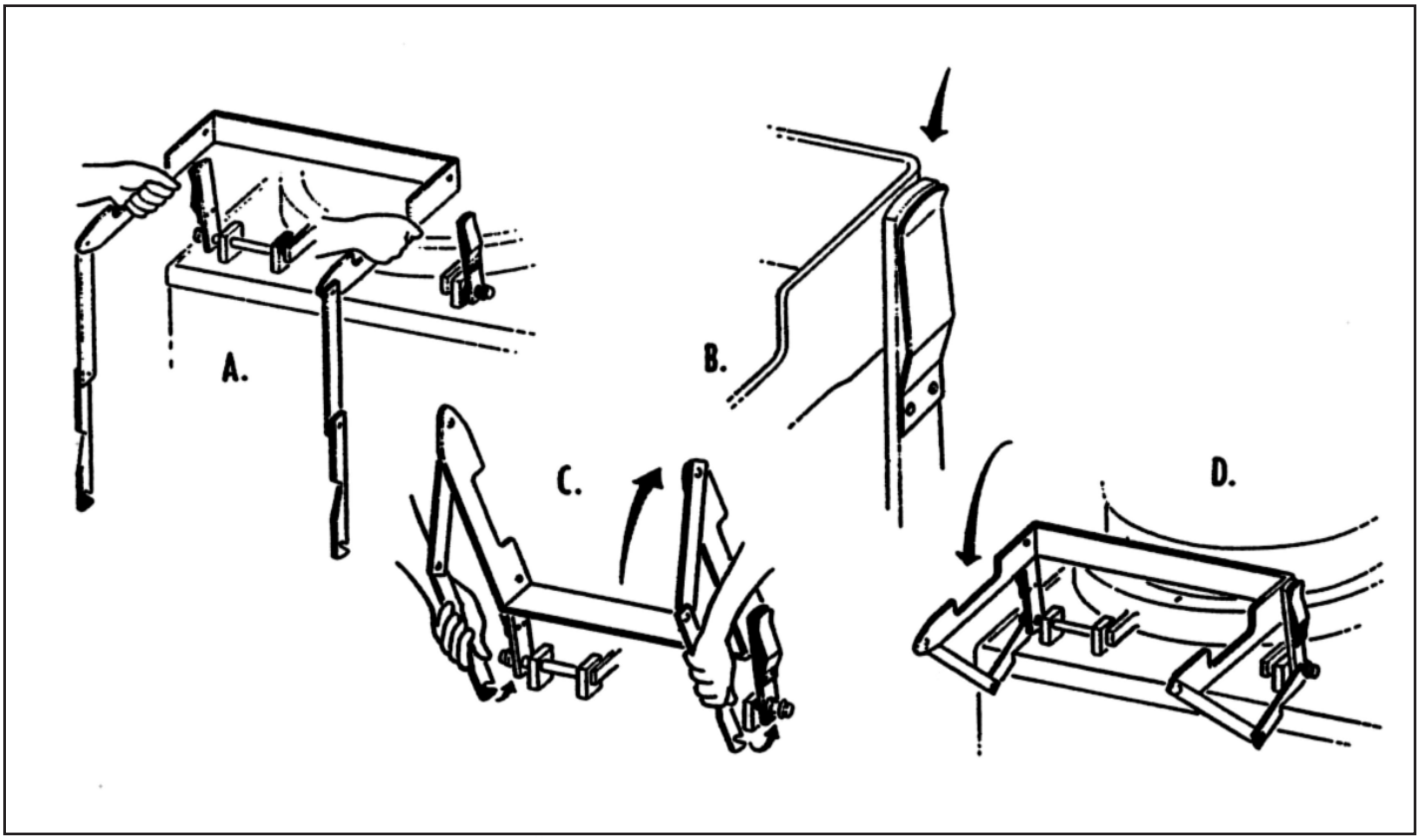


Figure 2-1
Mounting Pan Support

SECTION 3 maintenance

3.1 GENERAL

This section contains both preventive and corrective maintenance information. Preventive maintenance may be performed by maintenance personnel at the establishment in which the kettle is installed.

It is recommended that user personnel never attempt to make repairs or replacements to the equipment without the assistance of authorized service. Assistance in service methods or, a current Directory of Authorized Service Agencies may be obtained from Market Forge. (See Subsection 1.2).

3.2 PREVENTIVE MAINTENANCE

The most important preventive maintenance operation on the steam jacketed kettle is the cleaning procedure after each use described in Section 2. Additional preventive maintenance operations are presented in this section.

3.2.1 Cleaning

A policy should be faithfully observed of completing, by the end of each day's operation, all kettle cleaning procedures explained in Subsection 2.4.

In addition, cabinet doors, top, fixtures, kettle lid, etc., should be washed and rinsed to remove all food spills. For Chill Kettles, extra care must be given to cleaning the sink surrounding the kettle. Pan support should be removed as described in Subsection 2.5 and washed in a sink.

3.2.2 Tilting Mechanism Lubrication

Lubrication of the tilting mechanism of 25-, 40- and 60-gallon tilting kettles is the only required preventive maintenance other than daily cleaning. Inspect the screw of the tilting mechanism annually for adequate lubrication.

Should screw appear "dry" apply a good grade of ball bearing grease directly on the threads so that the threads appear to be barely damp. If mechanism fails to run smoothly (see paragraph 3.3.5.).

3.3 REPAIR & REPLACEMENT

In the event that the kettle fails to operate correctly, the difficulty should first be isolated to either the kettle itself or the steam supply which heats the kettle. While mechanical problems are obvious faults of the kettle, any deficiencies in volume and pressure of steam should be traced to the steam generator and the cause determined. Steam input requirements are listed in Appendix A, Modular Kettle Steam Requirements. Additional information may be found in separate service publications for steam generators.

3.3.1 Lid Counterbalance Adjustment

The kettle lid is equipped with a torsion spring counterbalance device to assist in lid lifting and to prevent slamming. The device is shown assembled in Figure 3-1 and exploded in Figure 4-11. If lid slams closed when handle is released, spring tension should be increased. If lid lifts up or refuses to remain down on kettle, tension should be reduced. To adjust spring tension proceed as follows:

1. Loosen 1/4" jam nut.

2. Adjust spring tension by turning 1/4" hex head cap screw. Tighten to increase tension; loosen to reduce tension.

3. Operate lid several times, repeating, step 2 until desired operation is obtained.

4. Hold hex head screw firmly in position and

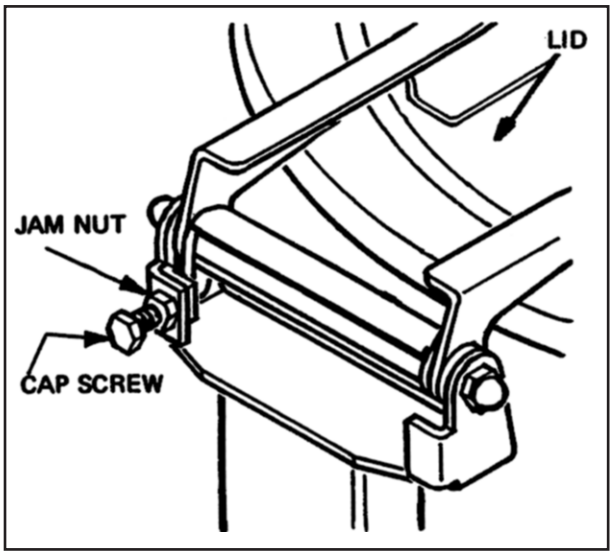


FIGURE 3-1
Lid Counterbalance Adjustment

Form No. S-2110 08/03
Printed in U.S.A.

3.3.2 Cabinet Exterior Removal

Side and rear panels of all cabinets in which kettles are mounted are easily removed without the use of tools. Each panel is grasped at the bottom edge and pulled out sharply to release it from the panel mounting brackets Shown in Figure 4-17 (12).

Replacement is completed by pushing panel up under cabinet top and pressing in at the bottom until panel mounting brackets are engaged. Doors may be removed to improve access to cabinet interior for repairs as shown In Figure 4-18.

The two flat head screws (10) and nuts (12) holding cabinet hinge (11) are removed and the door lifted out. When doors are remounted the final tightened position of hinge (11) determines the alignment of the door and must be set with care.

3.3.3 5 Gallon Trunnion Mounted Kettle Disassembly

Trunnion mounted kettles may be removed from the cabinet top for replacement of packing and seals which may become worn through use. The kettle mounting is shown in Figure 4-2 and is disassembled as follows:

1. Disconnect both steam inlet and condensate return plumbing connected to the pedestal inside the cabinet base.

2. Remove the three 3/8" bolts (4) and lock-washers (3) which fasten the kettle mount to the cabinet top. The kettle and mount may now be lifted from the cabinet.

3. Remove the four Allen Head set screws under one pedestal leg.
   NOTE: It is not necessary to remove both pedestal legs. All replaceable parts are exposed by removing one leg.

4. Disassemble .packing components (1) by pulling free leg from kettle. Replace worn parts as required.
   CAUTION: Packing rings on both sides of the kettle mount must be replaced each time mount is disassembled to assure a leakproof seal.

5. Reassemble in reverse order.

3.3.4 Draw-Off Valve Repair

An exploded view of the draw-off valve is shown in Figure 4-14. All parts are replaceable.

3.3.4.1 Common Leak Repairs: To repair a valve leak, the source must first be determined. Leaks from around the valve stem are corrected by replacing the rubber "0" ring (5) .Dripping from the valve outlet which occurs with the valve tightly closed indicates faulty seating of the valve disc (part of 6) against the valve seat. Dripping is often
corrected by cleaning residue from disc and seat using very fine emery.

3.3.4.2 Valve Seat Lapping: Should either the disc (part of 6) , or seat be found damaged it is necessaryb to either replace the entire valve or perform the lapping procedure as follows:

1. Disassemble the valve and clean both the disc and the valve seat.

2. Attach the handle (2) to the stem with the valve bonnet (4) removed.

3. Apply a good grade of fine lapping compound to the disc and insert it into the valve to make light contact against the seat.

4. Rotate the stem disc against the seat by turning the handle, allowing the stem to wobble in the space the bonnet would normally occupy. Continue with light pressure until compound dries.

5. Reassemble and test for leaks with valve closed. If dripping occurs repeat the lapping procedure as many times as required to obtain a watertight seal.

3.3.5 Tilting Mechanism Repair

Tilting kettles are equipped with tilting mechanisms shown in Figure 4-7 for 25- and 40- gallon kettles and Figure 4-9 for 60-gallon kettles. Though both .utilize the same screw assembly (2) , only Figure 4-7 includes brake disassembly detail and serves as the reference view for tilting mechan- ism repairs which follow.

3.3.5.1 Saginaw Screw Assembly Removal: The assembly is removed with the kettle in the lowered

1. Remove the two bolts (8) which hold the ball nut assembly in the screw lever (7).

2. Remove the two 5/16" hex head cap screws (13) which fasten the screw housing (14) to the cabinet frame (not shown).

3. Lift screw assembly from the cabinet.
Proceed in reverse order to replace the assembly.

3.3.5.2 General Inspection and Cleaning: The screw assembly should run smoothly throughout the entire stroke. If operation is not uniform remove the screw assembly (paragraph 3.3.5.1) and proceed as follows:

1. Inspect screw shaft for signs of accumulation of foreign matter in the ball grooves.

2. Using cleaning fluid or solvent remove dirt from ball grooves. Be sure to flush the ball nut assembly thoroughly.

3. Cycle the ball nut along the screw shaft several times. Wipe with a dry lintless cloth and lubricate immediately. (See lubrication 3.2.2).

4. If assembly continues to operate erratically after cleaning disassemble and inspect the ball nut assembly.

3.3.5.3 Ball Nut Disassembly: The Saginaw Screw is a ball bearing screw power transmission device which converts the turning motion applied by the hand crank (1) into bi-directional force against the screw lever (7).

The frictionless "easy" transfer results from the use of bearing balls circulated be- tween the screw and nut in concave helical grooves. As the screw rotates inside the nut, the bearing balls are directed from one end and carried by a ball guide to the opposite end of the ball nut. Figure 3-2 shows a cut-away view of the ball nut.

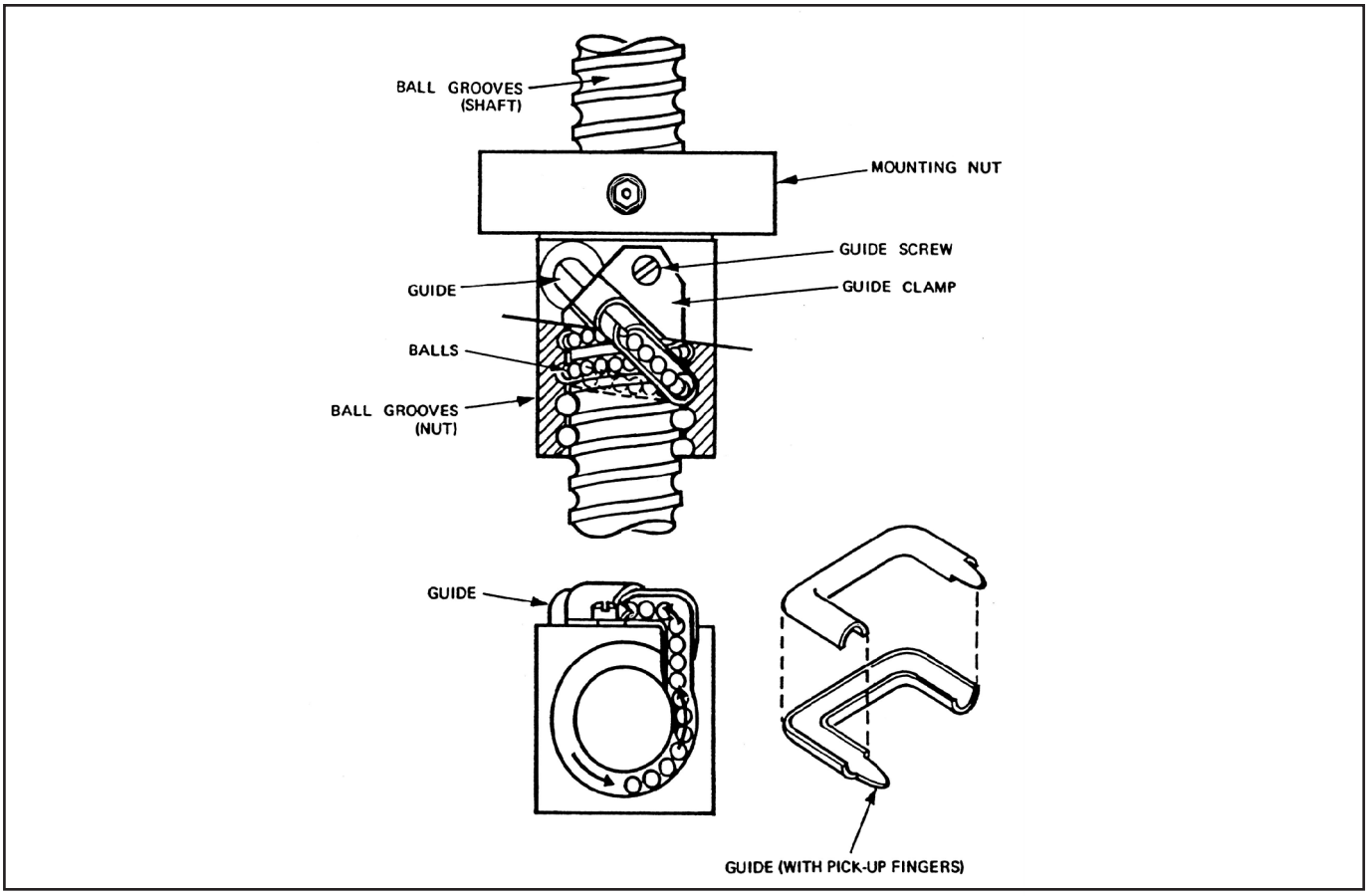


Figure 3-2
Ball Nut Assembly

Nut disassembly requires extreme care in handling to avoid loss of bearing balls and other small parts. The Saginaw Screw must be removed from the kettle (par.3.3.5.1) and the procedure completed over a clean work surface. A small clean container and clean cloth are required.

1. Place a clean cloth on the work surface with edges gathered to form a pocket to retain the bearing balls.
2. Place the Ball Nut Assembly over the pocket and remove the two Clamp Screws and the Guide Clamp.
3. Remove both halves of theGuidesimultaneously to prevent distortion of either half.
4. Catch all the Balls on the cloth by slowly rotating the Ball Nut on the screw. Place all balls in a small container.Take an accurate ball count and record.

> **CAUTION**
> Every bearing ball is required for reassembly. Exercise care in handling to avoid loss.

5. Remove the stop collar (5) held by set screw (3) at the free end of the screw shown in Figure 4-7.
6. Slide the Ball Nut off the free end of the screw.

3.3.5.4 Ball Nut Inspection: Disassembly of the ball nut must be completed to permit inspection (See par. 3.3.5.3). A Ball Bearing Replacement Kit containing bearing balls and ball guide is available from Market Forge parts distributors. Should the ball nut show excessive wear I the entire Saginaw Screw assembly must be replaced. Inspect components for wear points:

a. Balls. Check a random sample of 20 balls for signs of scuffing or fish scaling. Diameter variation between balls and trueroundness of each one must be within .0001 inch. Balls which fail to meet these requirements should be replaced using the Ball Bearing Replacement Kit.

b. Guide. Inspect the pick-up fingers which consist of short extensions at the end of each half guide. Minor burrs can be removed and the guide reused. If a ball impression appears on the finger tips or the halves were distorted during removal, the guide must be replaced.

c. Ball Nut. Inspect the internal threads of the ball nut for signs of excessive wear, pitting, gouges, corrosion or spalling in the ball groove area. If these flaws are detected, the entire Saginaw Screw assembly should be replaced.

3.3.5.5 Ball Nut Reassembly and Bearing Replacement: With the ball nut disassembled (par. 3.3.5.3) complete the following reassembly, using either existing bearing balls or substituting a Ball Bearing Replacement Kit (part number 91-1490).

1. Clean all ball nut components with a commercial solvent and dry thoroughly before reassembly.
2. Slide the ball.nut onto the free end of the screw, round nut end first, as shown in Figure 4-7.
3. Replace the stop collar (5) , Figure 4-7.

> **CAUTION**
> Bearing Balls are retained in the ball nut only when it is mounted on the screw. To prevent the nut from accidentally spinning off the screw the stop collar (or other obstruction) must be placed on the free end.

4. Center the ball nut grooves on the shaft grooves by inserting a cylindrical object (a drill bit shank, or other object of same diameter as bearing balls), into the ball nut return circuit hole. Carefully withdraw, taking care not to disturb nut-to-screw alignment.
5. Insert bearing balls into the guide opening using slight rotation of the screw to help feed them into the grooves. Place remaining balls into one half of the return guide.

> **NOTE**
> If a Ball Replacement Kit is to be installed, first count out the same number of new bearing balls as the number of worn balls being replaced. DO NOT try to add extra balls. There must be some free space in the circuit so that balls will roll and not skid.

6. Place a dab of bearing grease at each end of the half return guide to hold balls in place. Place the mating half return guide over the half filled with balls and insert the two ends of the ball guide into the holes in the ball nut. Seat by tapping gently with a rawhide or plastic mallet.

7. Inspect for free movement of the ball nut along the entire stroke. There should be no binding, squeal, or roughness at any point.

8. Place guide clamp in position and secure with clamp screws.

3.3.5.6 Crank Sleeve Replacement: The driving end of the Saginaw Screw (2) is formed into a slotted sleeve which receives the engagement pins of the removable hand crank (1). A worn or chipped sleeve which causes the hand crank to slip out of engagement during kettle tilting can be repaired with a Crank Sleeve Replacement Kit (part number 91-2155).

The Saginaw Screw assembly must be removed from the kettle to complete kit installation, (par. 3.3.5.1). The collar (next to the ratchet wheel, Fig. 4-7) is removed by driving out the roll pin which secures it to the screw shaft. The replacement sleeve is slid over the faulty shaft end and fastened with a roll pin. The repair is completed by re-mounting the Saginaw Screw assembly.

3.3.5.7 Brake Mechanism Disassembly and Repair: The brake mechanism, shown exploded in Figure 4-7, functions as an anti-coast device for the Saginaw Screw.

When the hand crank (1) is turned clockwise (kettle raising) , a ratchet wheel turns freely inside the ratchet stop. Any "free wheeling" counter clockwise screw motion is prevented by engagement of ratchet wheel teeth in the stop and the drag of friction between the shaft collar, and the ratchet wheel face. Additional torque applied by the hand crank, as in kettle lowering, over-powers the drag and allows the screw to turn with only mild resistance.

Failure of the brake mechanism to function as described requires removal of the Saginaw Screw assembly (per 3.3.5.1) and disassembly of the brake for cleaning.

1. Remove the shaft collar at the crank sleeve end by driving out the roll pin and sliding the collar off.

2. Slide the ratchet wheel off and inspect fol clean-liness. Use fine energy to remove an, build-up of soil or glaze on facings.

3. Thoroughly clean all brake mechanisn parts of dirt and lubricant.

4. Reassemble the mechanism taking care tha ratchet wheel is facing correctly. Replace, the Saginaw Screw assembly in the kettle cabinet.

SECTION 4 illustrated parts list

4.1 general

This section contains a complete listing off all replaceable parts of the modular kettles, and of a number of accessories. For the purpose of parts identification, a cut-away drawing is shown for each group of similar kettle models.

Exploded views of sub-assemblies are also provided where greater detail is needed. Table 4-1 lists commonly used accessories with a brief description and part number .

Each parts list contains the figure index number, the Market Forge part number and an abbreviated description. Care must be exercised in selecting the correct illustrated parts list. Check that kettle size and style coincide with that of equipment to be serviced.

4.2 ORDERING INFORMATION

Orders for repair parts should be directed to the nearest authorized parts d istributor. For a current Market Forge Authorized Parts Distributor List contact:

Customer Service Department, Market Forge
35 Garvey Street, Everett, Massachusetts02149
Telephone: (617)b387-4100

Customer Service Department, Canada, Ltd.
Market Forge
1375 Aimco Blvd., Unit 5,
Mississauga, Ontario, Canada,
Telephone: (416) 621-9252

All orders 'should contain the Market Forge part number(s) , the part description(s) , and the model and serial numbers of the kettle for which the part(s) is ordered.

list of illustrations

Figure *Page*

SECTION 4 illustrated parts list

4-1 5 Gallon Tilting Kettle 4-2
4-2 Trunnion Pedestal 4-3
4-3 Faucet, 5 Gallon Tilting Kettle 4-4
4-4 10-, 25- & 40- Gallon Stationary Kettle 4-5
4-5 60- Gallon Stationary Kettle 4-6
4-6 25- & 40- Gallon Tilting Kettle 4-7
4-7 Tilting Mechanism 25- & 40- Gallon Kettle 4-8
4-8 60- Gallon Tilting Kettle 4-9
4-9 Tilting Mechanism 60- Gallon Kettle 4-10
4-10 25- & 40- Gallon Chill Kettle 4-11
4-11 Hinge & Lid Assembly 4-12
4-12 Steam Supply Valve 4-13
4-13 Swing Dran 4-13
4-14 Draw-Off Valve 4-14
4-15 Steam-Trap 4-14
4-16 Faucet & Spout Assembly 4-15
4-17 18" Cabinet 4-16
4-18 24" Cabinet 4-17
4-19 36" Cabinet 4-18
4-20 48" Cabinet 4-19
4-21 12" Spacer with Sink & Faucet 4-20

Form No. S-2110 08/03
Printed in U.S.A.

SECTION 4 illustrated parts list

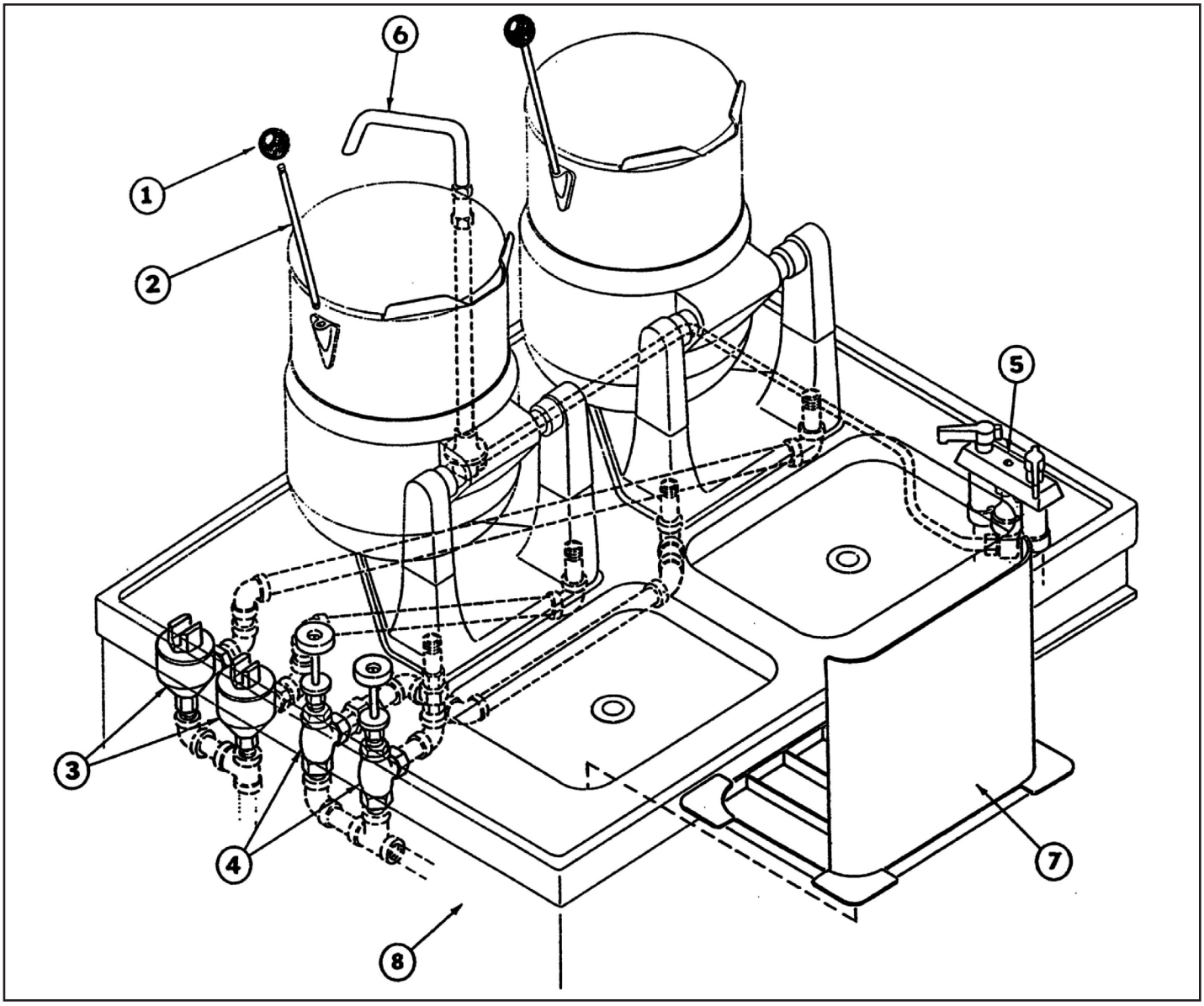


figure 4-1
5 Gallon tilting kettle

fig. 4-1 index no.	part no.	description
1	10-0060	KNOB
2	10-6148	KETTLE ARM
3	10-4755	STEAM TRAP
4	10-5242	1/2" ANGLE STEAM VALVE, (SEE FIG. 4-12)
5	10-3556	FAUCET, (SEE FIG. 4-3)
6	10-5753	SWIVEL SPOUT, (SEE FIG. 4-3)
7A	90-0167	SPLASH SHIELD, SHALLOW SINK
7B	90-0168	SPLASH SHIELD, DEEP SINK
8A	--	18" CABINET, (SEE FIG. 4-17)
8B	--	36" CABINET, (SEE FIG. 4-19)

Form No. S-2110 08/03
Printed in U.S.A.

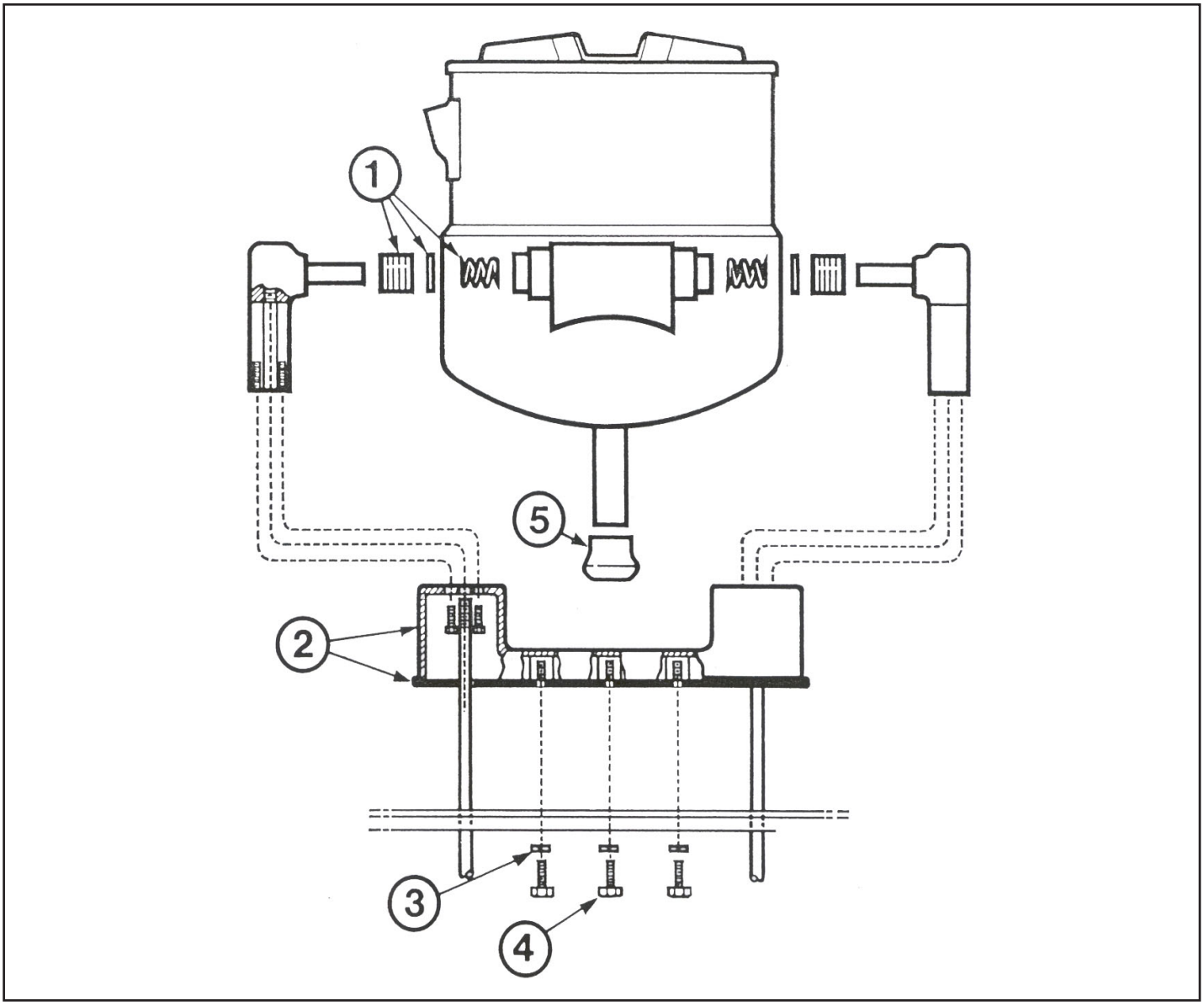


figure 4-2
TRUNNION PEDESTAL

fig. 4-2 index no.	part no.	description
1	10-5337	REPLACEMENT PACKING, TRUNNION
2	10-6428	PEDESTAL & GASKET REPLACEMENT KIT
3	10-2503	LOCKWASHER, 3/8"
4	10-2034	HEX HEAD BOLT, 3/8" X 3/4" LG.
5	10-0220	FOOT REST, RUBBER

Form No. S-2110 08/03
Printed in U.S.A.

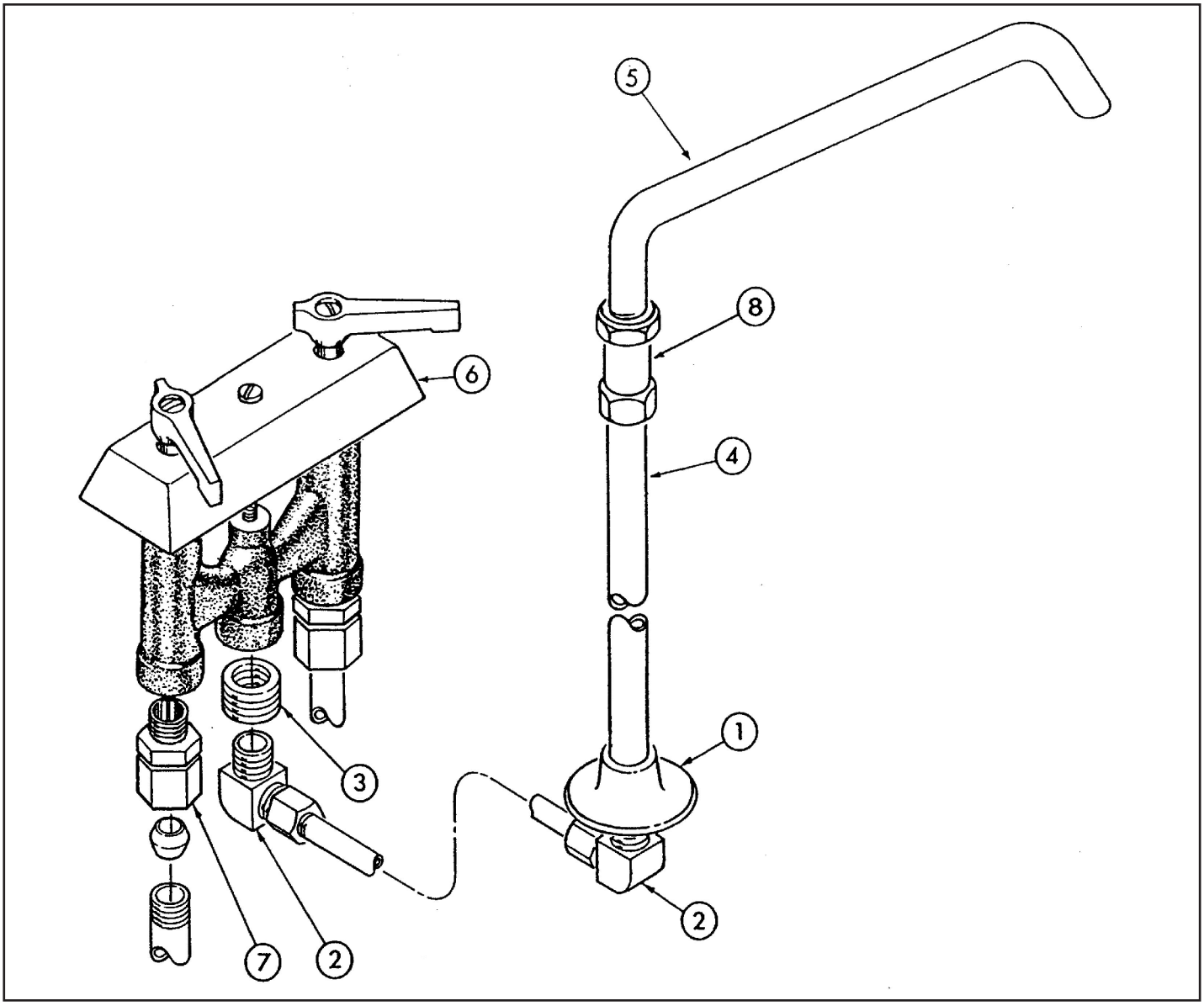


figure 4-3
FAUCET - 5 GALLON TILTING KETTLE

fig. 4-3 index no.	part no.	description
1	10-3108	MOUNTING BASE, RISER
2	10-3357	ADAPTER, 90°
3	10-3741	REDUCING BUSHING
4	10-3766	RISER, 15"
5	10-5753	SWIVEL SPOUT
6	10-3556	FAUCET
7	10-3684	COMPRESSION FITTING, MALE
8	10-1100	SWIVEL BODY

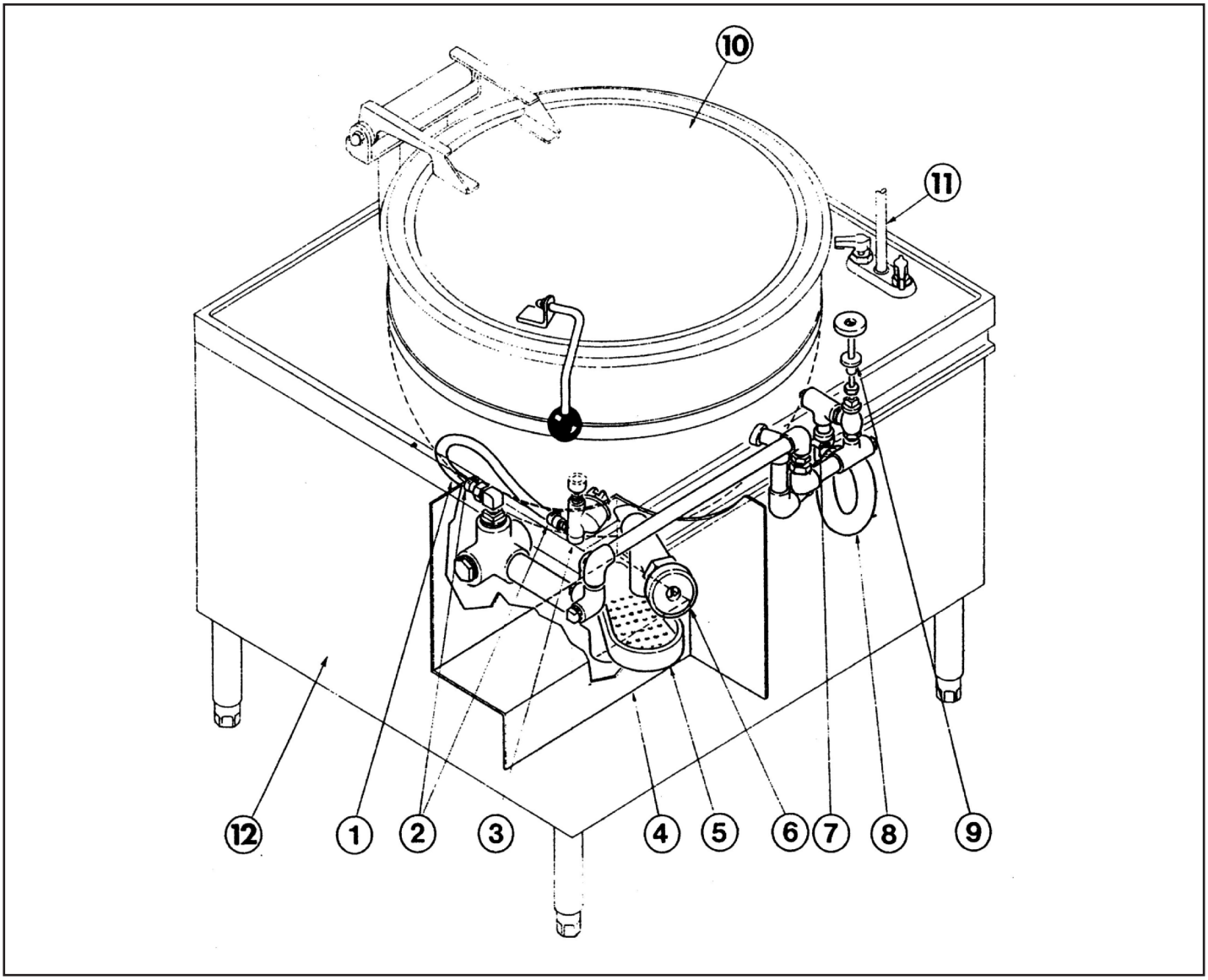


figure 4-4 10-, 25- AND 40- GALLON STATIONARY KETTLE

fig. 4-4 index no.	part no.	description
1	90-7491	CONDENSATE HOSE, 3/8" I.D.
2	10-3945	CLAMP, CONDENSATE HOSE
3	10-5319	STEAM TRAP W/ HOSE FITTING, (SEE FIG. 4-15)
4	90-8725	SPLASH GUARD ASSEMBLY
5	91-1834	SWING DRAIN, (SEE FIG. 4-13)
6	10-4928	1 1/2" DRAW-OFF VALVE, (SEE FIG. 4-14)
7	10-3916	CLAMP, STEAM HOSE
8	90-7496	STEAM HOSE, 3/4" I.D.
9	10-5242	1/2" ANGLE STEAM VALVE, (SEE FIG. 4-12)
10	--	HINGE & LID ASSEMBLY, (SEE FIG. 4-11)
11	--	FAUCET & SPOUT ASSEMBLY, (SEE FIG. 4-16)
12A	--	24" CABINET, (SEE FIG. 4-18)
12B	--	36" CABINET, (SEE FIG. 4-19)

Form No. S-2110 08/03
Printed in U.S.A.

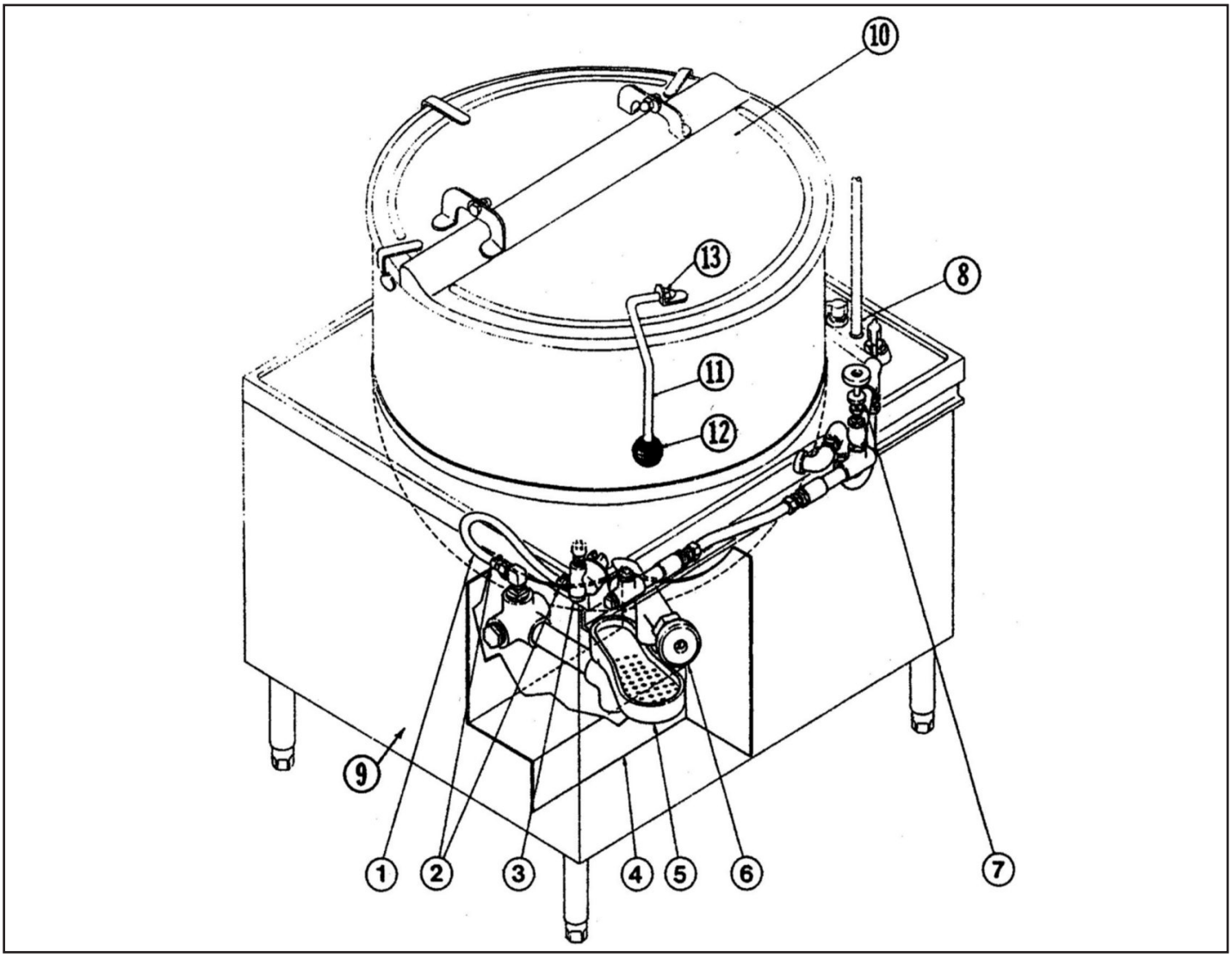


figure 4-5 60 gallon stationary kettle

fig. 4-5 index no.	part no.	description
1	90-7491	CONDENSATE HOSE, 3/8" I.D.
2	10-3945	CLAMP, CONDENSATE HOSE
3	10-5319	STEAM TRAP W/ HOSE FITTING, (SEE FIG. 4-15)
4	90-8725	SPLASH GUARD ASSEMBLY
5	91-1834	SWING DRAIN (SEE FIG. 4-13)
6	10-4928	1 1/2" DRAW-OFF VALVE, (SEE FIG. 4-14)
7	10-5242	1/2" ANGLE STEAM VALVE, (SEE FIG. 4-12)
8	--	FAUCET & SPOUT ASSEMBLY, (SEE FIG. 4-16)
9	--	36" CABINET, (SEE FIG. 4-19)
10	90-9050	LID ASSEMBLY, 60 GALLON STATIONARY KETTLE
11	91-1523	HANDLE ARE, 60 GALLON STATIONARY KETTLE
12	10-0060	KNOB, PLASTIC
13	10-2355	ACORN NUT

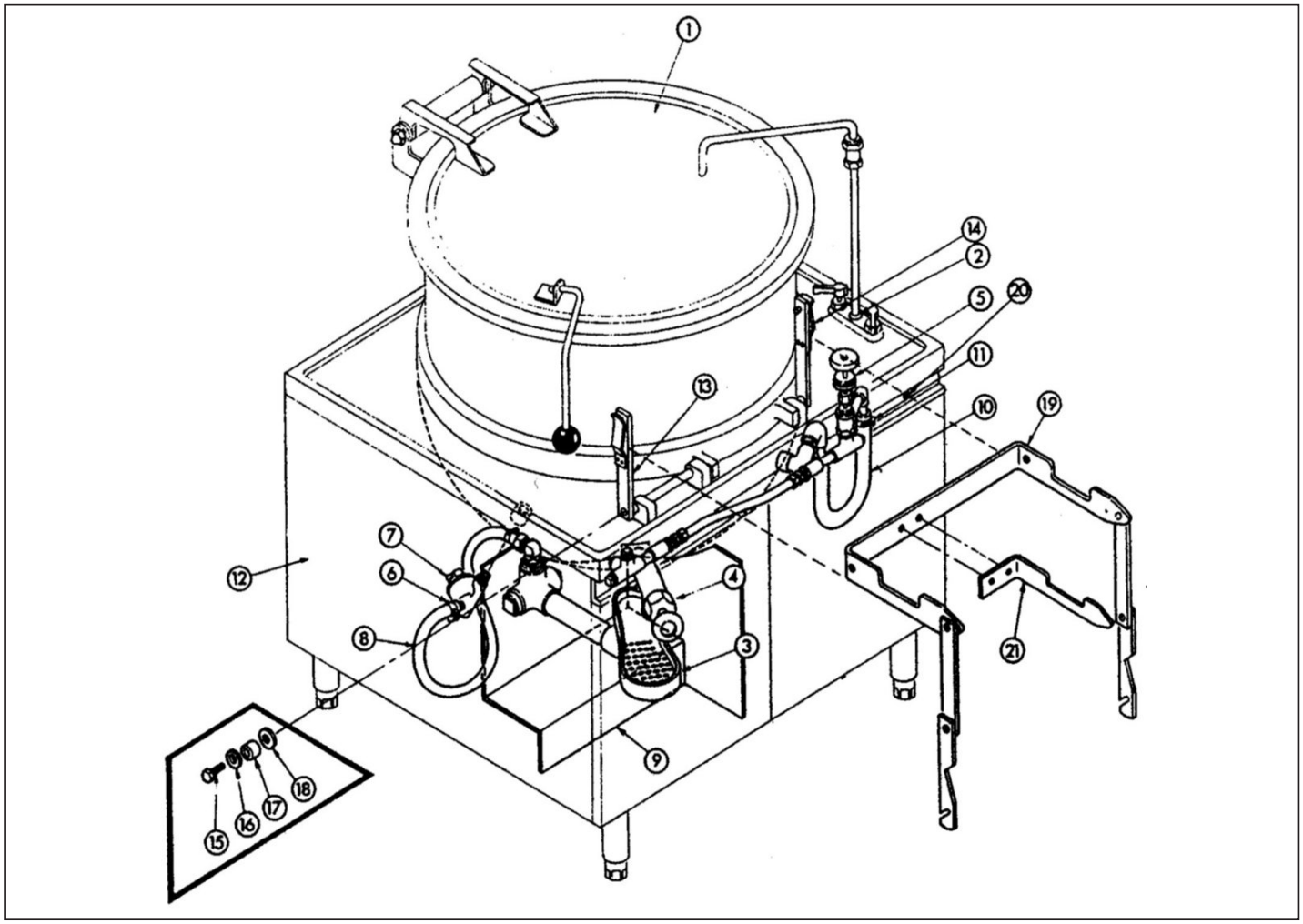


figure 4-6 25- & 40- GALLON TILTING KETTLES

fig. 4-6 index no.	part no.	description
1	--	HINGE & LID ASSEMBLY, (SEE FIG. 4-11)
2	--	FAUCET & SPOUT ASSEMBLY, (SEE FIG. 4-16)
3	91-1834	SWING DRAIN, (SEE FIG. 4-13)
4	10-4928	1 1/2" DRAW-OFF VALVE, (SEE FIG. 4-14)
5	10-5242	1/2" ANGLE STEAM VALVE, (SEE FIG. 4-12)
6	10-3945	CLAMP, CONDENSATE HOSE
7	10-5319	STEAM TRAP WITH HOSE FITTING, (SEE FIG. 4-15)
8	90-7493	CONDENSATE HOSE, 3/8" I.D. 36" LONG
9	90-8725	SPLASH GUARD ASSEMBLY
10	90-7495	STEAM HOSE, 3/4" I.D.
11	10-3916	CLAMP, STEAM HOSE
12	--	36" CABINET, (SEE FIG. 4-19)
13	90-3788	PAN SUPPORT UPRIGHT, LEFT
14	90-3783	PAN SUPPORT UPRIGHT, RIGHT
15	10-1791	MACHINE SCREW, 1/4" X 7/8" LONG
16	10-2403	WASHER, 1/4"
17	10-6784	SPACER, SMALL
18	90-3476	SPACER, LARGE
19	90-0326	PAN SUPPORT, REMOVABLE
20	--	TILTING MECHANISM, (SEE FIG. 4-7)
21	90-3796	PAN SUPPORT ADAPTER (OPTIONAL)

Form No. S-2110 08/03
Printed in U.S.A.

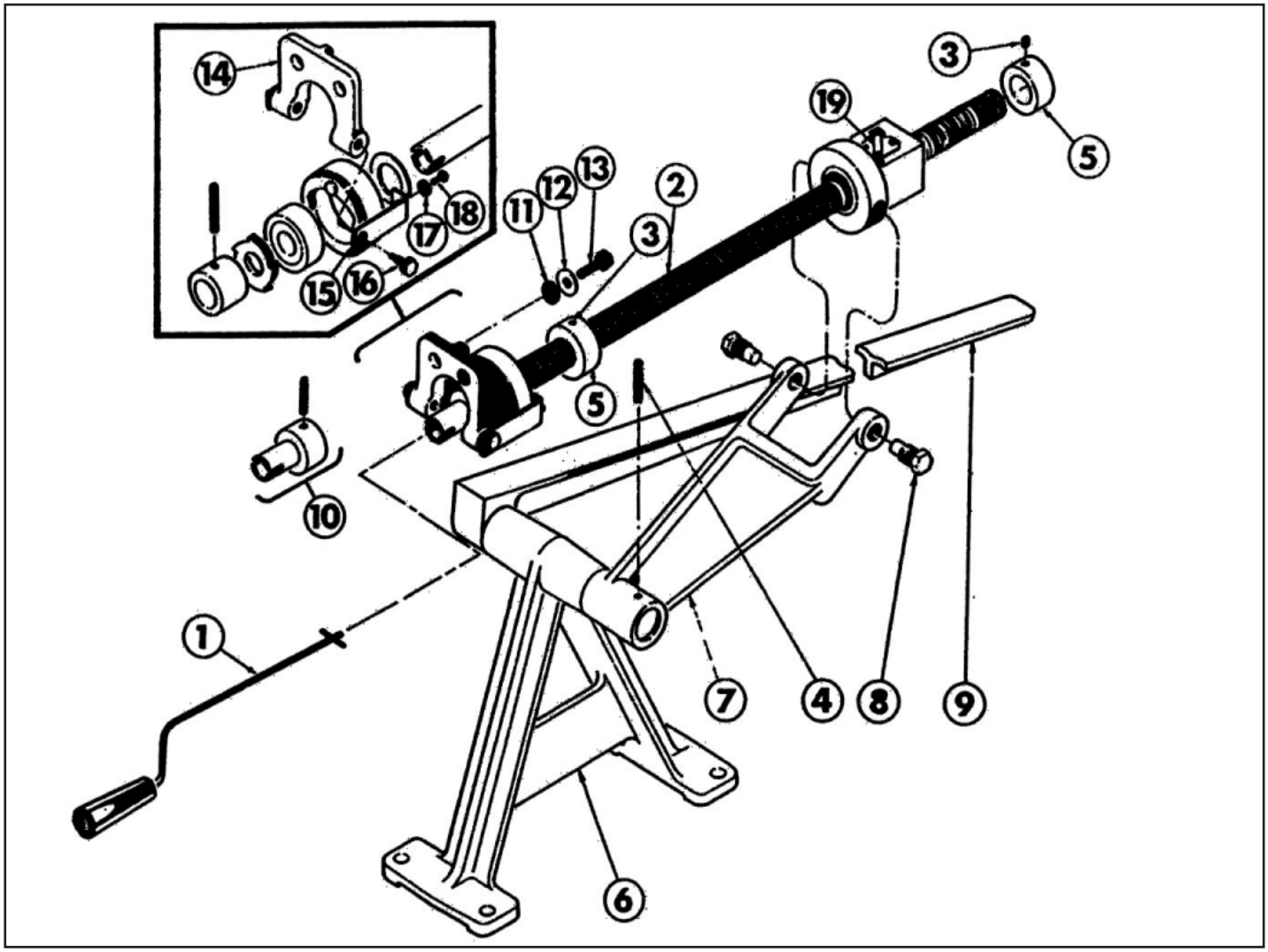


figure 4-7 tilting mechanism 25- & 40- gallon kettles

fig. 4-7 index no.	part no.	description
1	90-4037	HAND CRANK
2	90-8728	SAGINAW SCREW ASSEMBLY, COMPLETE
3	10-3026	SET SCREW, ALLEN HEAD, 5/16 - 18 X 5/16"
4	10-2610	ROLL PIN, 3/8" X 2" LONG
5	10-3591	STOP COLLAR
6	90-8754	'A' FRAME
7	90-8755	SCREW LEVER
8	90-8710	BOLT 1/2 - 13, SPECIAL
9	90-9449	LEVER ARM ASSEMBLY
10	91-2155	CRANK SLEEVE REPLACEMENT KIT
11	10-2511	LOCK WASHER, 5/16"
12	10-2405	WASHER, 5/16"
13	10-2042	HEX HEAD CAP SCREW, 5/16 - 18 X 1"
14	90-8757	SCREW HOUSING
15	90-8732	BRAKE MOUNTING BRACKET
16	90-8731	SHOULDER SCREW
17	10-2508	LOCK WASHER, 1/4"
18	10-1907	HEX HEAD CAP SCREW, 1/4 - 20 X 5/8"
19	91-1490	BALL BEARING REPLACEMENT KIT

Form No. S-2110 08/03
Printed in U.S.A.

SECTION 4 illustrated parts list

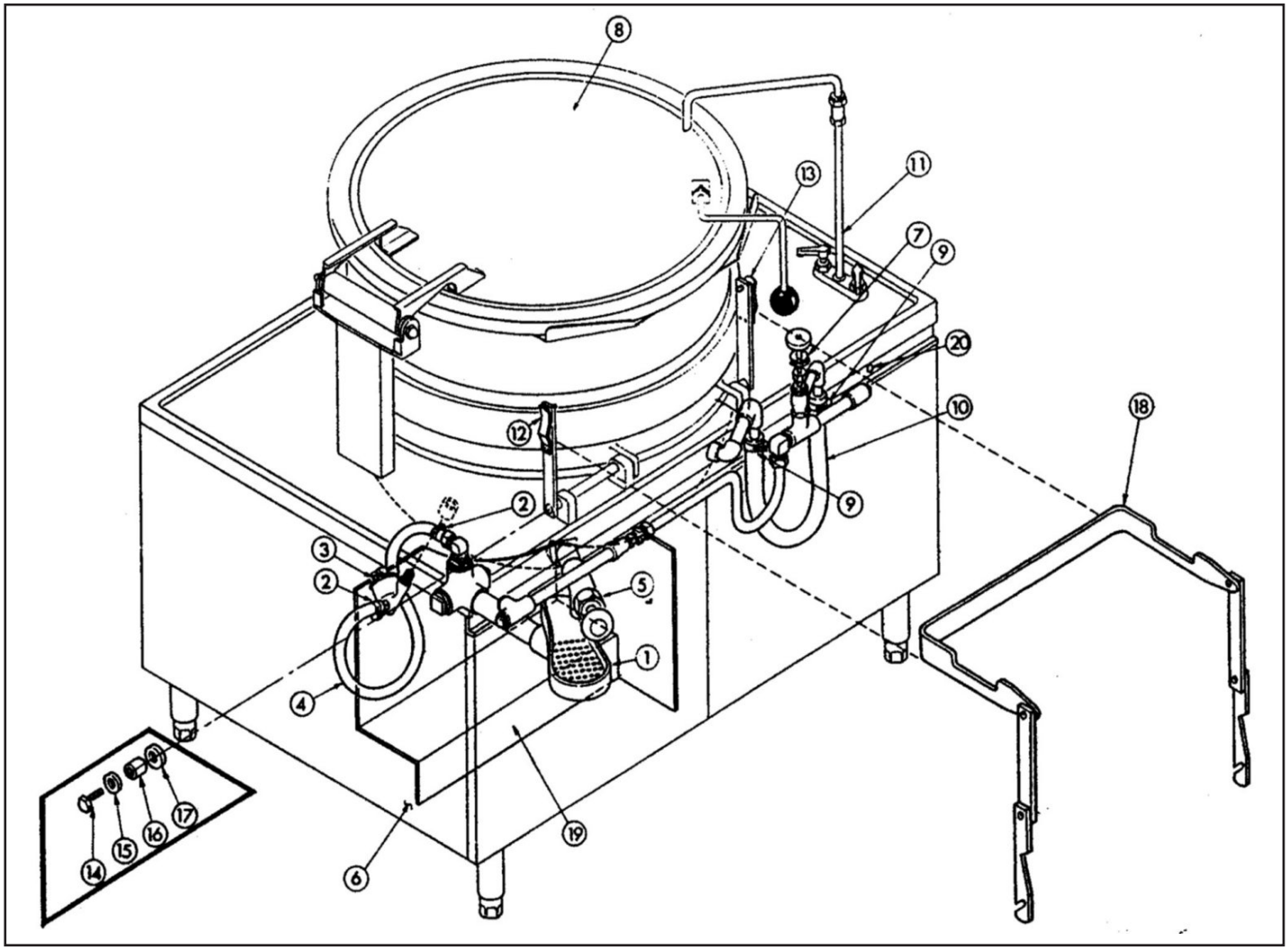


figure 4-8 60 gallon TILTING kettles

fig. 4-8 index no.	part no.	description
1	91-18347	SWING DRAIN (SEE FIG. 4-13)
2	10-3945	CLAMP, CONDENSATE HOSE
3	10-5319	STEAM TRAP W/ HOSE FITTING, (SEE FIG. 4-15)
4	90-7493	CONDENSATE HOSE, 3/8" I.D.
5	10-4928	1 1/2" DRAW-OFF VALVE, (SEE FIG. 4-14)
6	--	48" CABINET, (SEE FIG. 4-20)
7	10-5242	1/2" ANGLE STEAM VALVE, (SEE FIG. 4-12)
8	10-6796	HINGE & LID ASSEMBLY, (SEE FIG. 4-11)
9	10-3916	CLAMP, STEAM HOSE
10	91-1977	STEAM HOSE, 3/4" I.D.
11	--	FAUCET & SPOUT ASSEMBLY, (SEE FIG. 4-16)
12	91-1839	PAN SUPPORT UPRIGHT, LEFT
13	91-1838	PAN SUPPORT UPRIGHT, RIGHT
14	10-1791	MACHINE SCREW, 1/4" X 7/8" LONG
15	10-2403	WASHER, 1/4"
16	10-6784	SPACER, SMALL
17	90-3476	SPACER, LARGE
18	91-1983	PAN SUPPORT, REMOVABLE
19	90-8725	SPLASH GUARD ASSEMBLY
20	--	TILTING MECHANISM, (SEE FIG. 4-9)

Form No. S-2110 08/03
Printed in U.S.A.

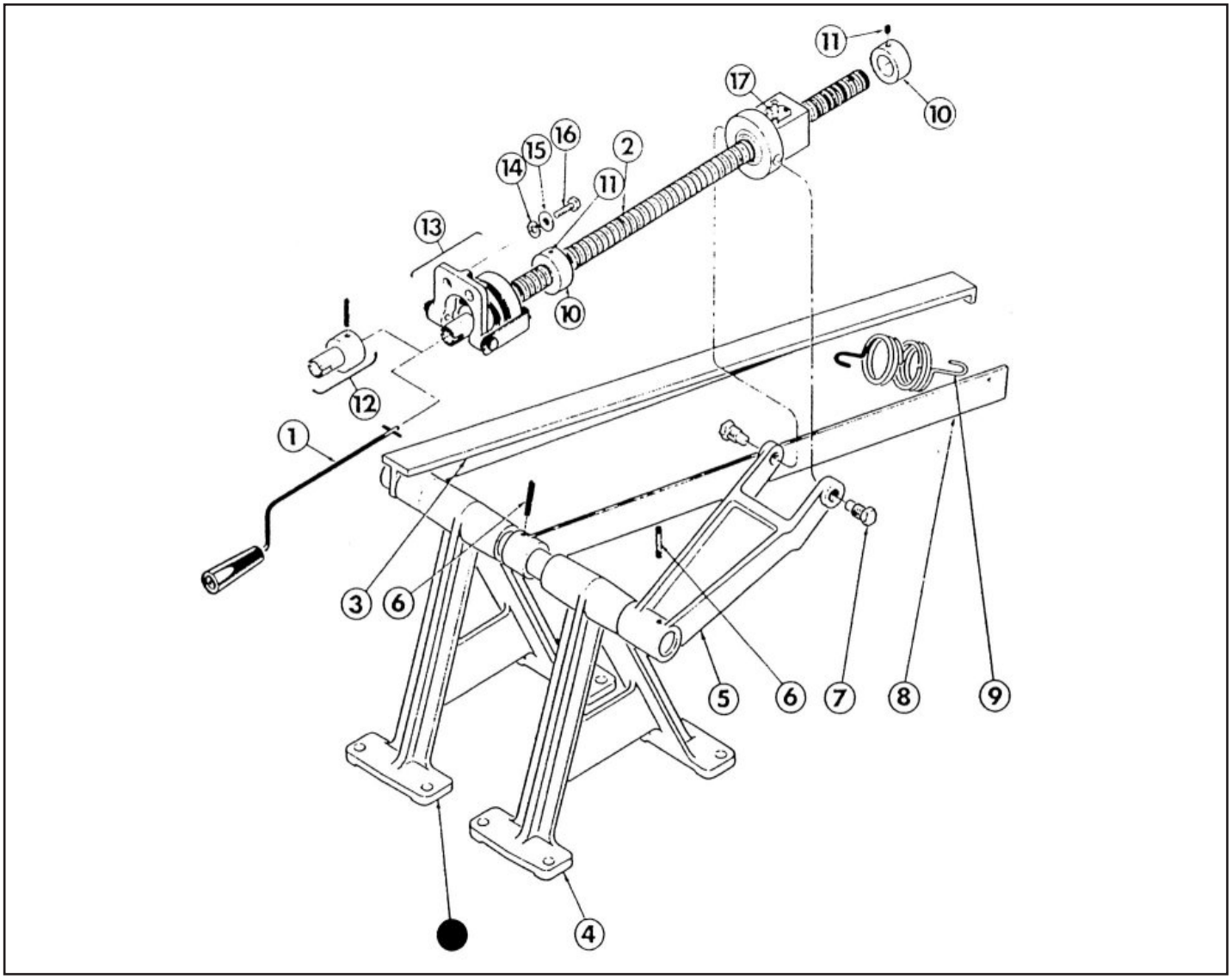


figure 4-9 tilting mechanism 60- gallon kettle

fig. 4-9 index no.	part no.	description
1	90-4037	HAND CRANK
2	90-8728	SAGINAW SCREW ASSEMBLY, COMPLETE
3	91-1959	LEVER ARM ASSEMBLY
4	90-8754	'A' FRAME
5	90-8755	SCREW LEVER
6	10-2310	ROLL PIN, 3/8" X 2" LONG
7	90-8710	BOLT 1/2 - 13, SPECIAL
8	91-1992	SPRING SUPPORT ASSEMBLY
9	10-2746	EVTENTION SPRING
10	10-3591	STOP COLLAR
11	10-3026	SET SCREW, ALLEN HEAD, 5/16 - 18 X 5/16"
12	91-2155	CRANK SLEEVE REPLACEMENT KIT
13	--	BRAKE & MOUNTING ASSEMBLY, (SEE FIG. 4-7)
14	10-2511	LOCK WASHER, 5/16"
15	10-2405	WASHER, 5/16"
16	10-2042	HEX HEAD CAP SCREW, 5-16 - 18 X 1"
17	91-1490	BALL BEARING REPLACEMENT KIT

Form No. S-2110 08/03
Printed in U.S.A.

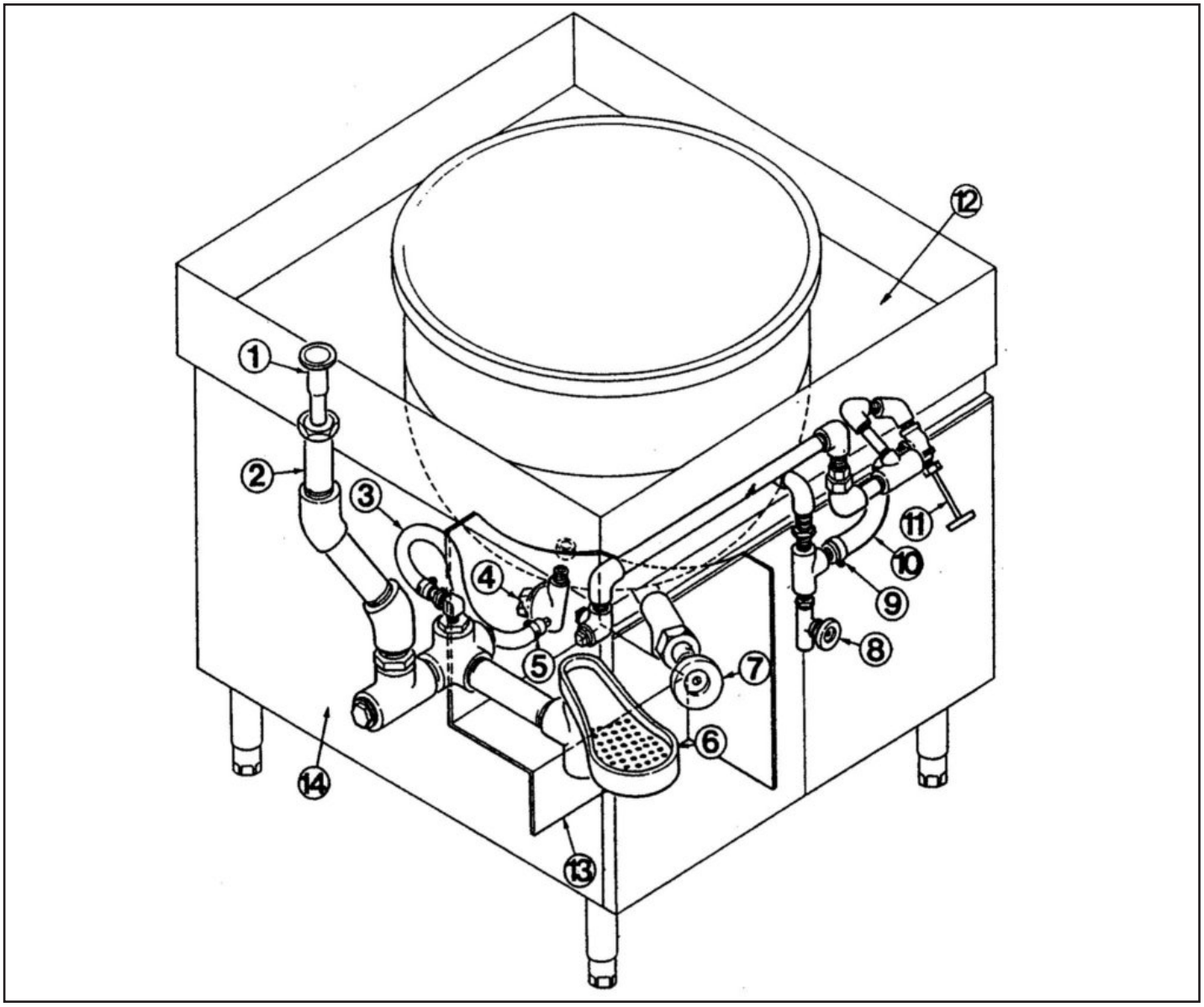


figure 4-10 25- & 40- CHILL kettles

fig. 4-10 index no.	part no.	description
1	10-3161	BASIN WASTE DRAIN
2	10-3897	NIPPLE, 1 1/2" X 5"
3	90-7491	CONDENSATE HOSE, 3/8" I.D.
4	10-5319	STEAM TRAP W/ HOSE FITTING, (SEE FIG. 4-15)
5	10-3916	CLAMP, CONDENSATE HOSE
6	91-1834	SWING DRAIN, (SEE FIG. 4-13)
7	10-4928	1 1/2" DRAW-OFF VALVE, (SEE FIG. 4-14)
8	90-5201	CHILL LINE ASSEMBLY
9	10-3945	CAMP, STEAM HOSE
10	90-1305	STEAM HOSE, 3/4" I.D.
11	10-5242	1/2" ANGLE STEAM VALVE
12A	90-4914	SINK, 25 GALLON CHILL KETTLE
12B	90-4915	SINK, 40 GALLON CHILL KETTLE
13	90-8725	SPLASH GUARD ASSEMBLY
14	--	36" CABINET, (SEE FIG. 4-19)

Form No. S-2110 08/03
Printed in U.S.A.

SECTION 4 illustrated parts list

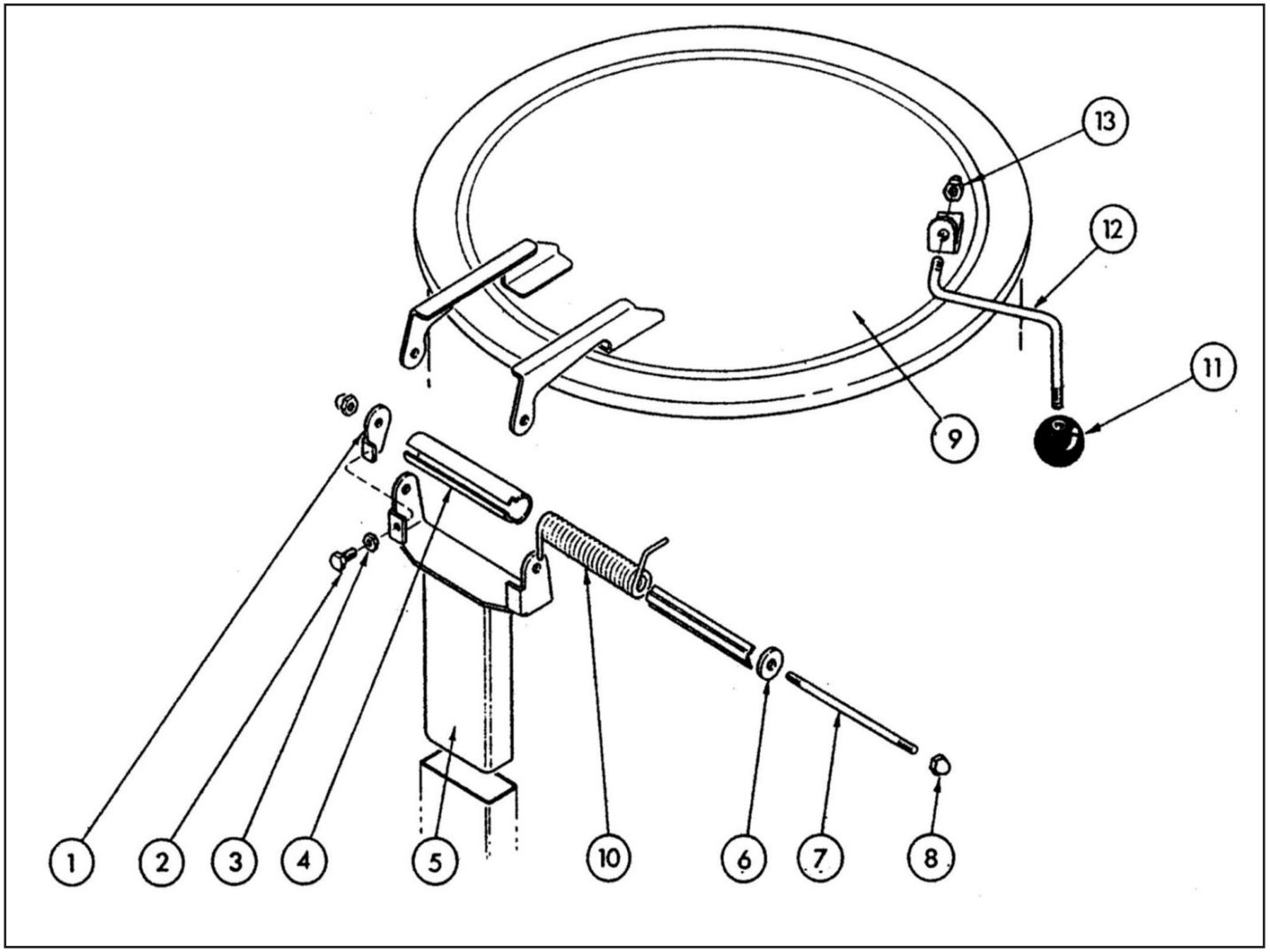


figure 4-11 HINGE & LID ASSEMBLY

fig. 4-11 index no.	part no.	description
1	91-1565	ADJUSTMENT PLATE
2	10-1814	HEAD CAP SCREW, 1/4 - 20 X 3/4"
3	10-2336	HEX NUT, 1/4 - 20
4	91-1232	TORSION SPRING COVER
5A	91-1685	TOP BRACKET & HINDGE SUPPORT ASSY 25 & 40 GAL
5B	91-1938	TOP BRACKET & HINDGE SUPPORT ASSY 60 GAL
6	10-2448	NYLON WASHER
7	90-3042	TORSION SPRING RETAINING ROD
8	10-2359	ACORN NUT, 1/4 - 20
9A	91-2012	KETTLE COVER ASSY, 25 GAL STATIONARY
9B	90-7701	KETTLE COVER ASSY, 25 GAL TILTING
9C	90-3949	KETTLE COVER ASSY, 40 GAL STATIONARY/TILTING
9D	91-1963	KETTLE COVER ASSY, 60 GAL TILTING
10	10-2747	TORSION SPRING
11	10-0060	KNOB, PLASTIC
12A	91-1523	ARM, LID (25, 40 & 60 GAL TILTING/40 & 60 STATIONARY)
12B	91-2011	ARM, LID (25 STATIONARY)
12C	90-0171	ARM, LID (10 STATIONARY)
13	10-2355	ACORN NUT

Form No. S-2110 08/03
Printed in U.S.A.

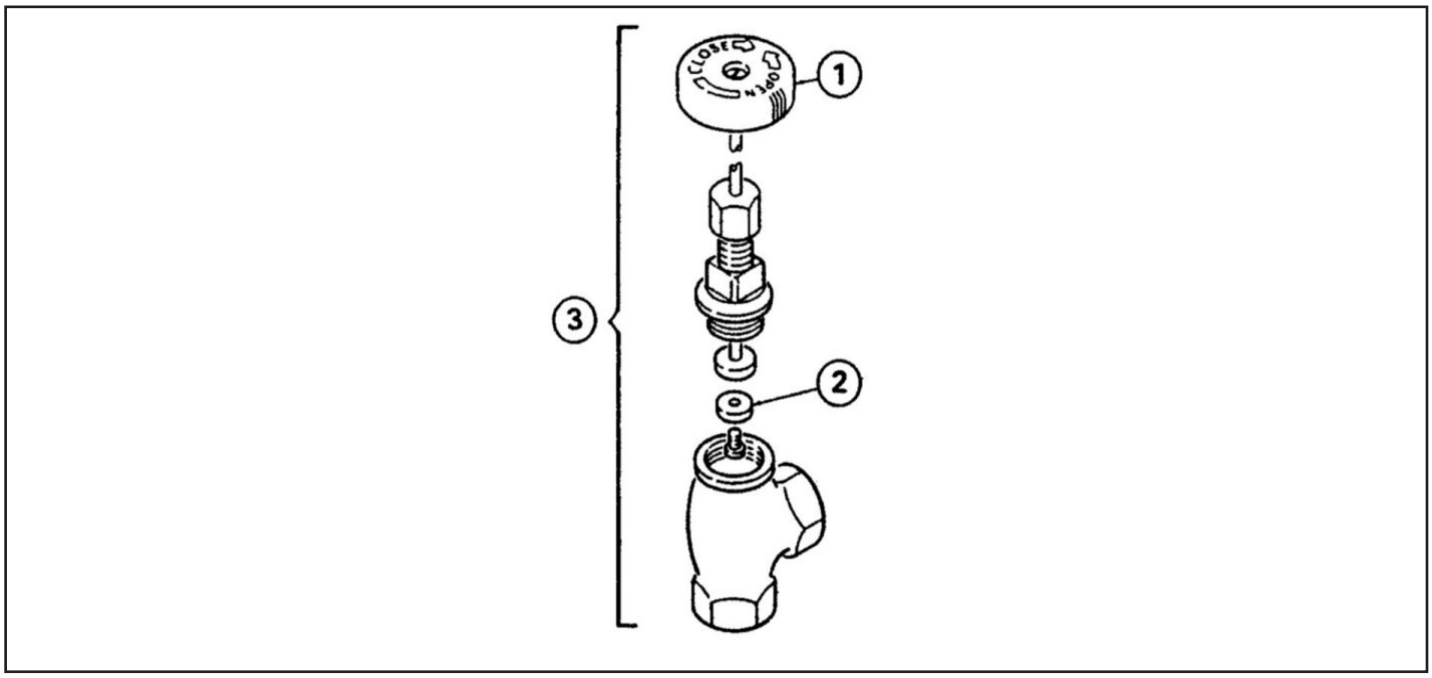


figure 4-12 STEAM SUPPLY VALVE

fig. 4-12 index no.	part no.	description
1	10-0105	STEAM VALVE HANDLE
2	10-5247	VALVE DISC
3	10-5242	1/2" ANGLE STEAM CONTROL VALVE

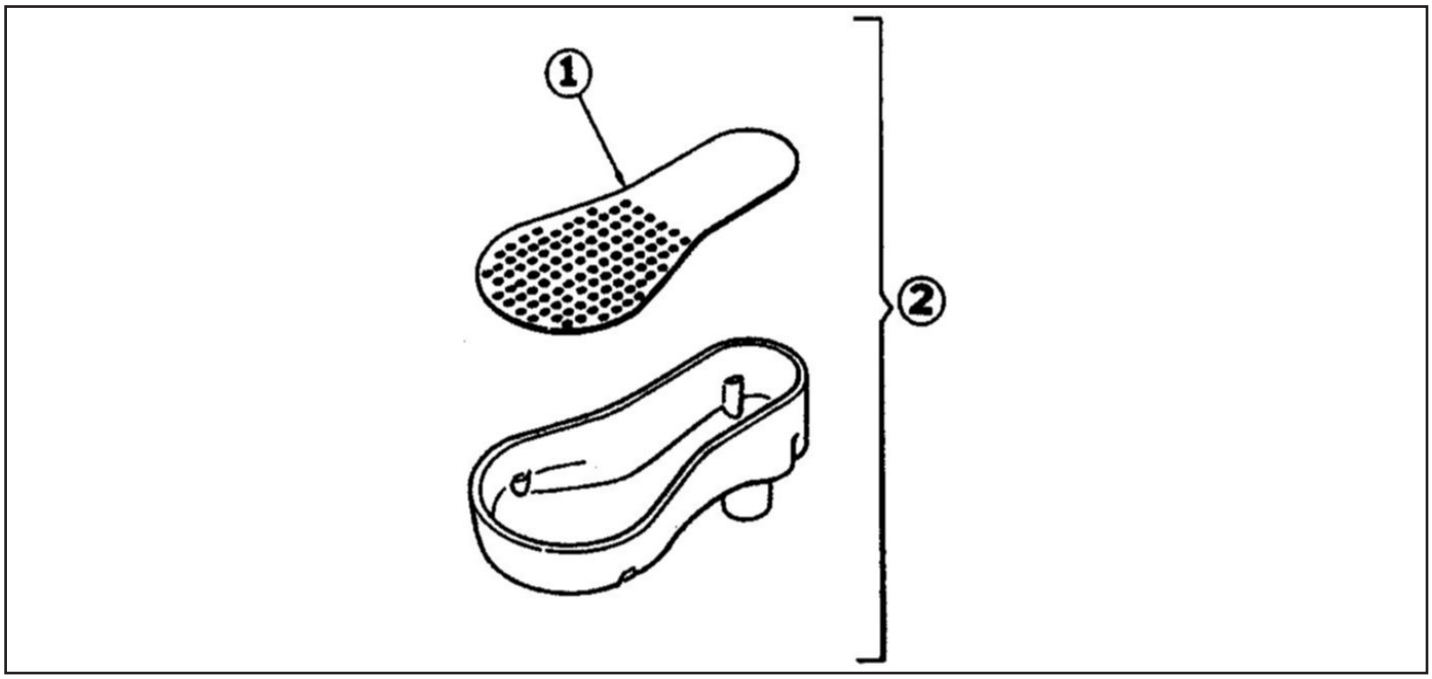


figure 4-13 SWING DRAIN

fig. 4-13 index no.	part no.	description
1	91-1835	STRAINER, SWING DRAIN
2	91-1834	SWING DRAIN, COMPLETE

Form No. S-2110 08/03
Printed in U.S.A.

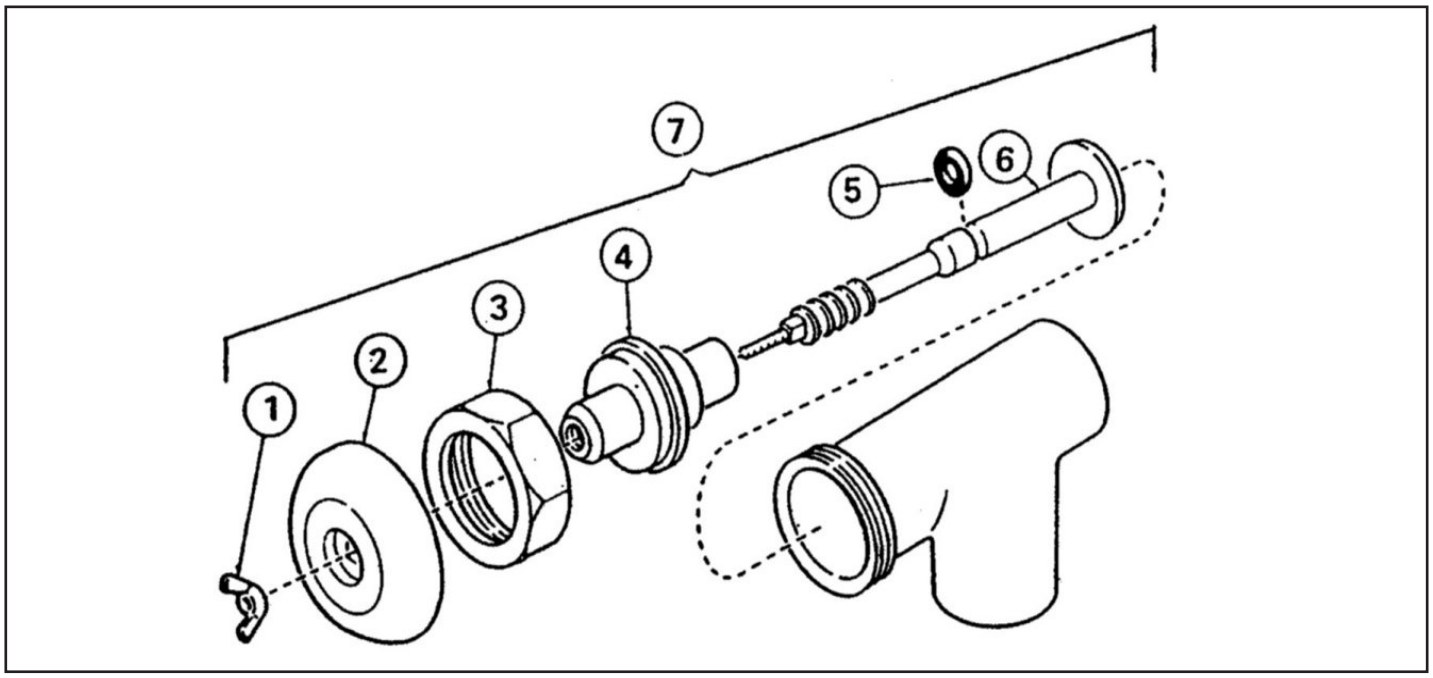


figure 4-14 DRAW-OFF VALVE

fig. 4-14 index no.	part no.	description
1	10-4972	WING NUT
2	10-4971	HANDLE
3	10-4970	HEX NUT
4	10-4968	BONNET
5	10-4969	'O' RING, RUBBER
6	10-4967	STEM
7	10-4928	1 1/2" DRAW-OFF VALVE, COMPLETE

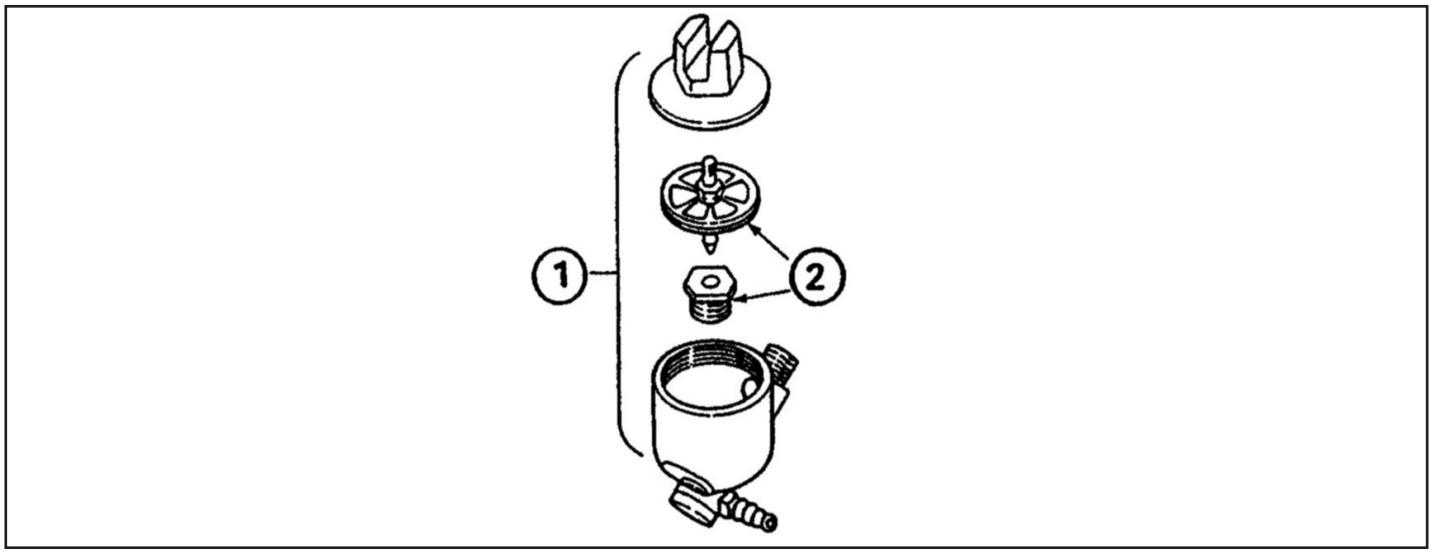


figure 4-15 STEAM TRAP

fig. 4-15 index no.	part no.	description
1A	10-5319	1/2" STEAM TRAP^{W}/HOSE FITTING (10, 25, 40 & 60 GAL KETTLES)
1B	10-4755	1/2" STEAM TRAP^{W}/HOSE FITTING (5 GAL KETTLES)
2	10-4937	THERMOSTAT, STEAM TRAP

Form No. S-2110 08/03
Printed in U.S.A.

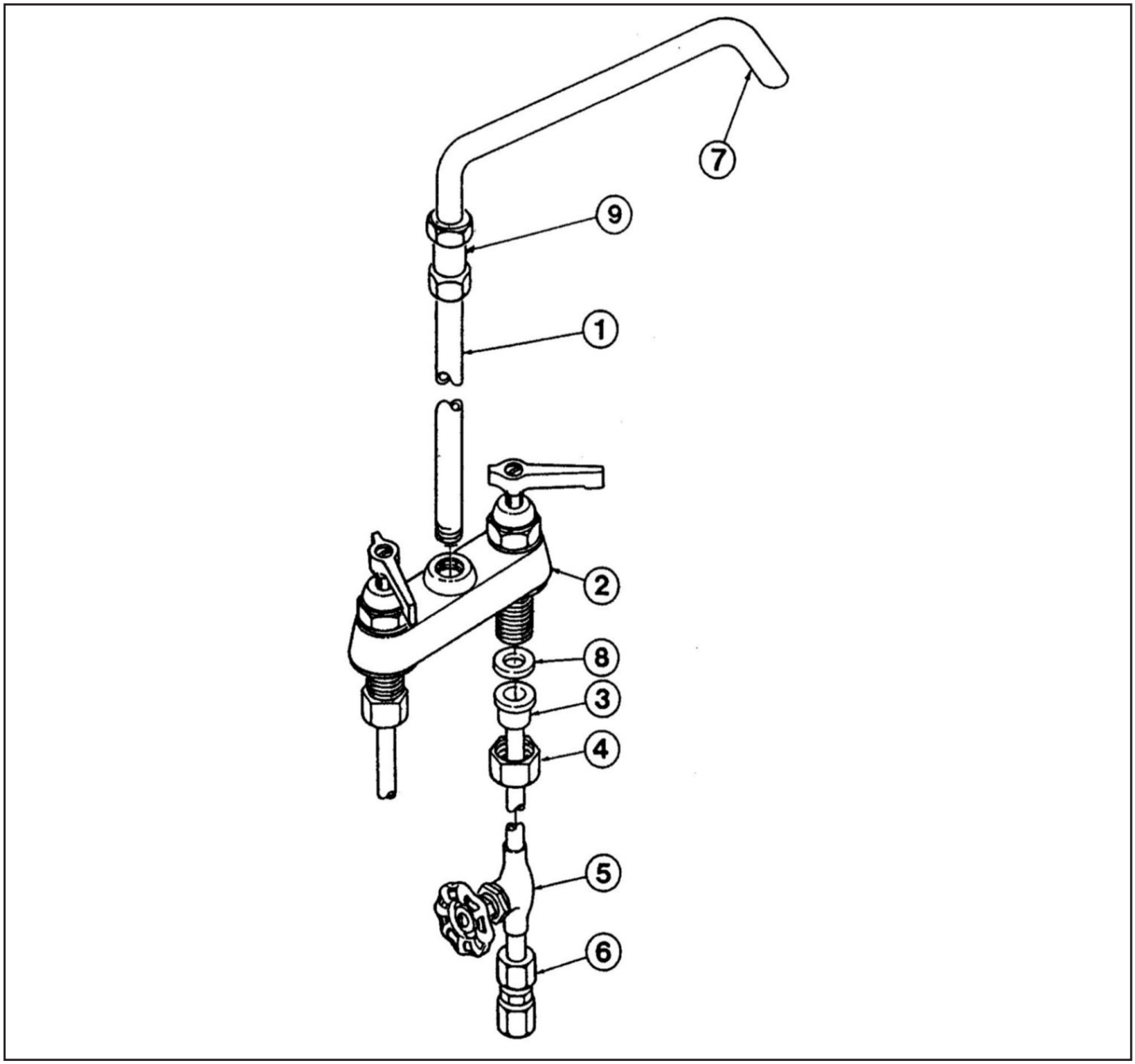


figure 4-16 FAUCET & SPOUT ASSEMBLY

fig. 4-16 index no.	part no.	description
1A	10-3766	RISER, 25, 40 & 60 GAL KETTLES
1B	10-3768	RISER, 10 GAL KETTLES
2	10-5921	FAUCET
3	10-0990	TAILPIECE, 1/2" O.D. TUBE
4	10-0991	COUPLING NUT
5	10-0996	STOP VALVE, 3/8"
6	10-1324	UNION, COMPRESSION, 1/2" O.D.
7	10-5753	SWIVEL SPOUT
8	10-0989	FIBER WSHER
9	10-1100	SWIVEL BODY

Form No. S-2110 08/03
Printed in U.S.A.

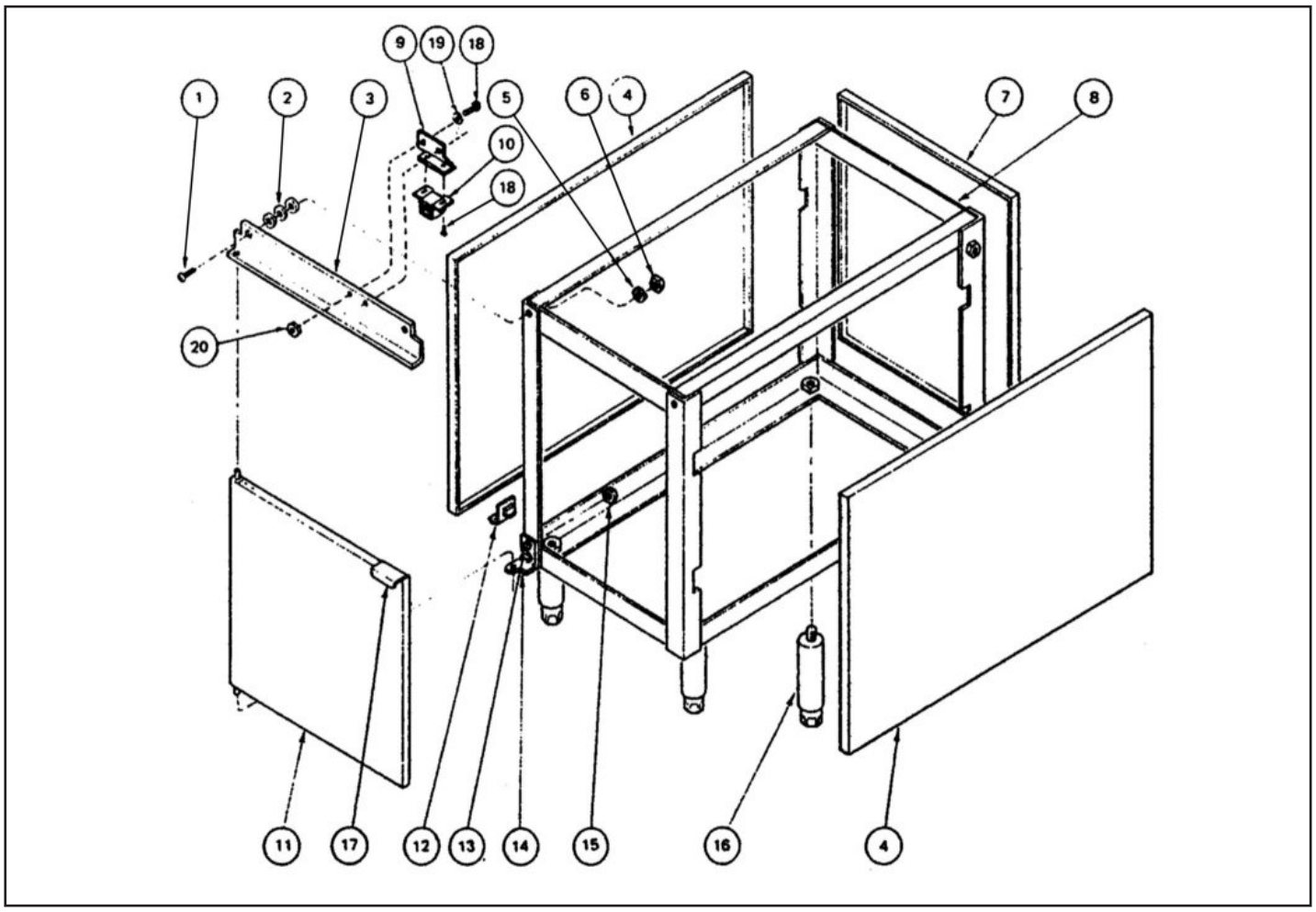


figure 4-17 18" CABINET

fig. 4-17 index no.	part no.	description
1	10-2143	HEX HEAD CAP SCREW, 5-16 - 18" X 1 1/4"
2	10-2405	WASHER, 5/16"
3	10-0492	FEATURE STRIP, 18"
4	90-2661	SIDE PANEL, STAINLESS STEEL
5	10-2511	LOCKWASHER, 5/16"
6	10-2307	NUT, 5/16 - 18
7	90-2656	REAR PANEL, STAINLESS STEEL
8	90-9440	FRAME ASSEMBLY, 18" X 33"
9	90-3210	BRACKET, MAGNETIC CATCH
10	10-5561	MAGNETIC CATCH
11A	90-9061	DOOR ASSY, RIGHT HAND, STAINLESS STEEL (NOT SHOWN)
11B	90-9062	DOOR ASSY, LEFT HAND, STAINLESS STEEL
12	90-2663	PANEL MOUNTING BRACKET
13	10-1869	SCREW, 10/32 X 1/2" FLAT HEAD
14A	10-0453	HINGE, LEFT, BOTTOM
14B	10-0454	HINGE, RIGHT, BOTTOM (NOT SHOWN)
15	10-2545	HEX NUT & LOCKWASHER, 10/32"
16	10-0631	LEG, ADJUSTABLE
17	90-9057	DOOR HANDLE
18	10-1722	MACHINE SCREW, 6/32 X 3/8" ROUND HEAD
19	10-2515	LOCKWASHER #6
20	10-2337	NUT, 6/32"

Form No. S-2110 08/03
Printed in U.S.A.

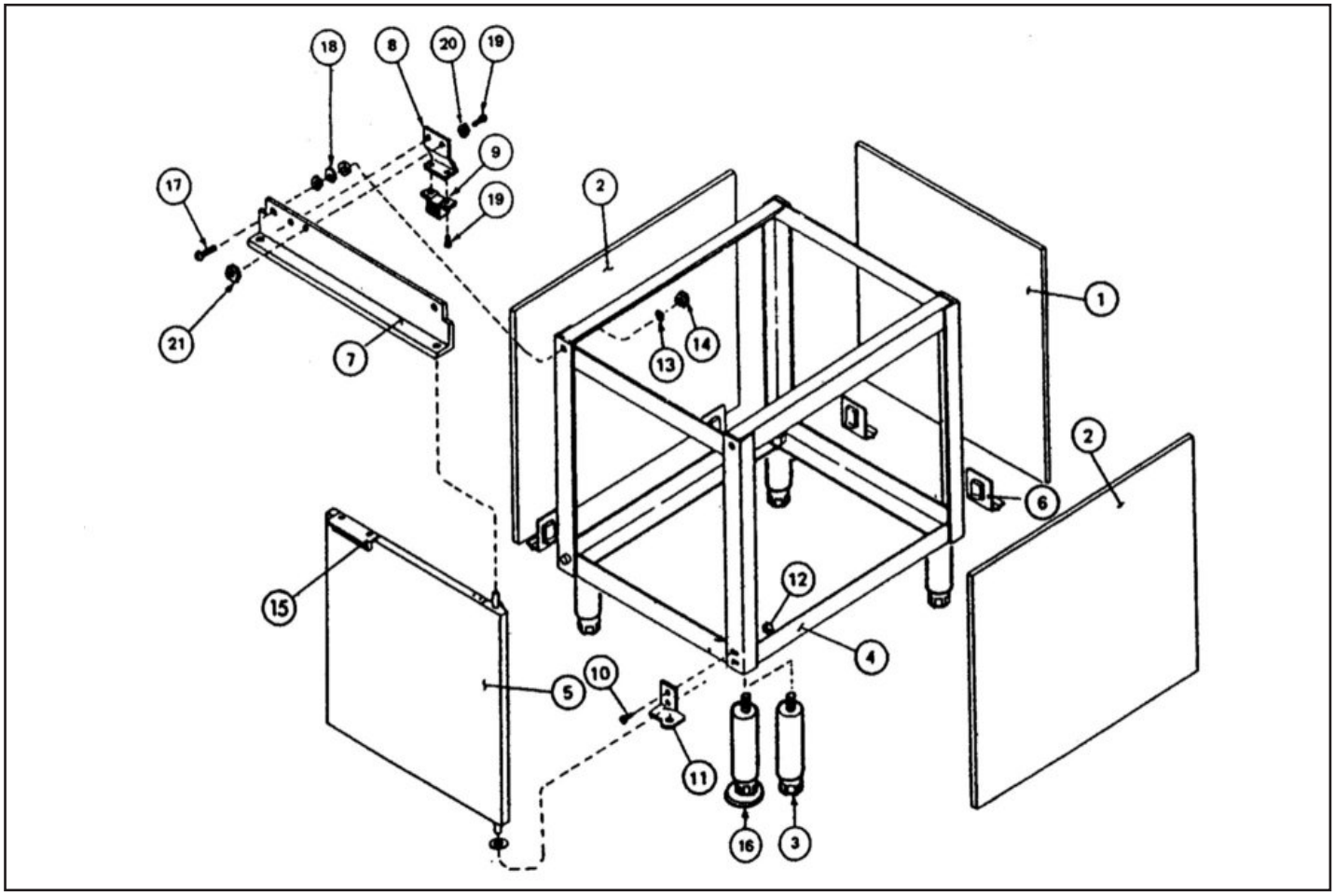


figure 4-18 24" CABINET

fig. 4-18 index no.	part no.	description
1	90-2657	REAR PANEL, STAINLESS STEEL
2	90-2661	SIDE PANEL, STAINLESS STEEL
3	10-0631	LEG, ADJUSTABLE
4	90-8974	FRAME ASSY, 24" x 33"
5A	90-2993	DOOR ASSY, LEFT HAND, STAINLESS STEEL (NOT SHOWN)
5B	90-3154	DOR ASSY, RIGHT HAND, STAINLESS STEEL
6	90-2663	PANEL MOUNTING BRACKET
7	10-0493	FEATURE STRIP, 24"
8	90-3210	BRACKET, MAGNETIC CATCH
9	10-5561	MAGNETIC CATCH
10	10-1869	SCREW, 10/32 x 1/2" Flat Head
11A	10-0454	CABINET HINGE, RIGHT, BOTOM
11B	10-0453	CABINET HINGE, LEFT, BOTOM (NOT SHOWN)
12	10-2545	HEX NUT & LOCKWASHER, 10/32"
13	10-2511	LOCKWASHER,5/16"
14	10-2307	NUT, 5/16- 18
15	90-9057	DOOR HANDLE
16	10-0636	LEG, ADJUSTABLE, w/Flnge (IF REQUIRED)
17	10-2143	HEX HEAD CAP SCREW, 5/16 -18 x 1-1/4"
18	10-2405	WASHER, 5/16"
19	10-1722	MACHINE SCREW, 6/32 x 3/8", ROUND HEAD
20	10-2515	LOCKWASHER, #6
21	10-2337	NUT, 6/32"

Form No. S-2110 08/03
Printed in U.S.A.

SECTION 4 illustrated parts list

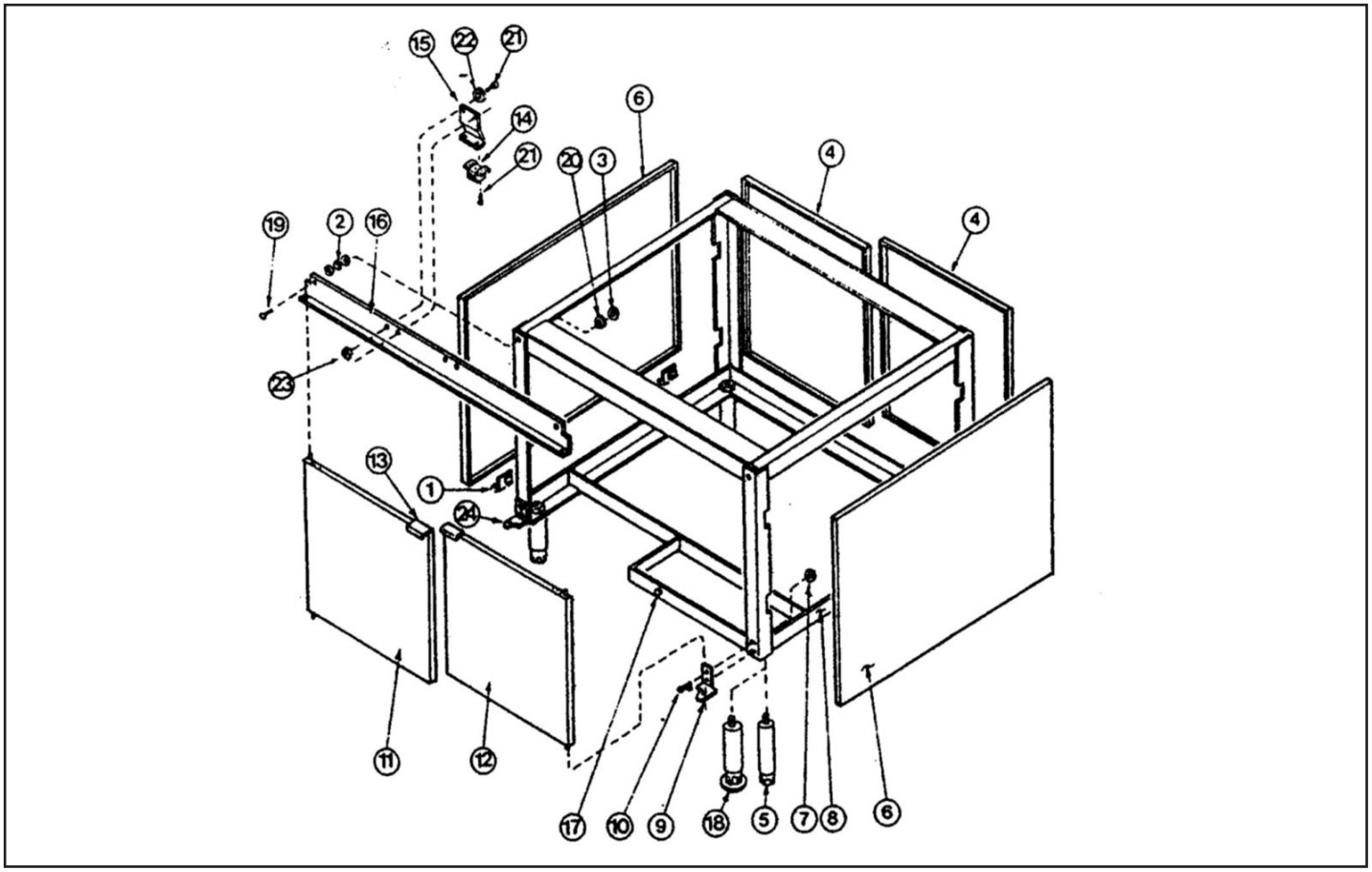


figure 4-19 36" CABINET

fig. 4-19 index no.	part no.	description
1	90-2663	PANEL MOUNTING BRACKET
2	10-2405	WASHER, 5/16"
3	10-2307	NUT, 5/16 -18
4	90-2656	REAR PANEL, STAINLESS STEEL
5	10-0631	LEG, ADJUSTABLE
6	90-2661	SIDE PANEL, STAINLESS STEEL
7	10-2545	HEX NUT & LOCKWASHER, 10/32"
8	90-9023	FRAME ASSEMBLY, 36" X 33"
9	10-0454	DOOR HINGE, RIGHT BOTTOM
10	10-1869	SCREW, 10/32 X 1/2", FLAT HEAD
11	90-9062	DOOR ASSEMBLY, LEFT HAND, STAINLESS STEEL
12	90-9061	DOOR ASSEMBLY, RIGHT HAND, STAINLESS STEEL
13	90-9057	DOOR HANDLE
14	10-5561	MAGNETIC CATCH
15	90-3210	BRACKET, MAGNETIC CATCH
16A	10-0494	FEATURE STRIP, 36" STATIONARY KETTLE
16B	10-0495	FEATURE STRIP, 36", TILTING KETTLE
17	10-0257	STEM BUMPER
18	10-0636	LEG, ADJUSTABLE, w/FLANGE (IF REQUIRED)
19	10-2143	HEX HEAD CAP SCREW, 5/16 -18 X 1-1/4"
20	10-2511	LOCKWASHER, 5/16"
21	10-1722	MACHINE SCREW, 6/32 X 3/8", ROUND HEAD
22	10-2515	LOCKWASHER, #6
23	10-2337	NUT, 6/32"
24	10-0453	DOOR HINGE, LEFT BOTTOM

Form No. S-2110 08/03
Printed in U.S.A.

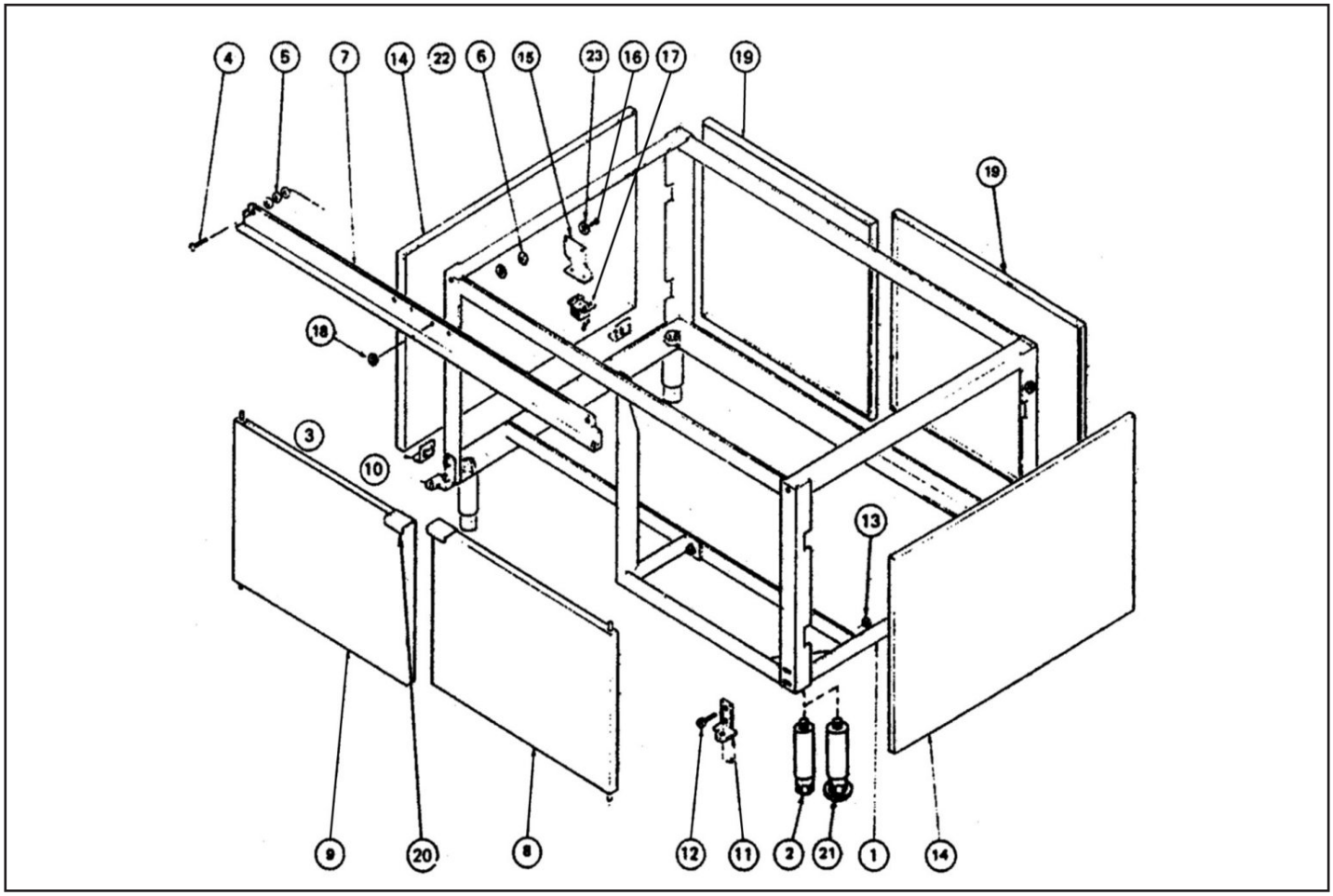


figure 4-20 48" CABINET

fig. 4-20 index no.	part no.	description
1	91-1784	FRAME ASSEMBLY, 48" X 33"
2	10-0631	LEG, ADJUSTABLE
3	90-2663	PANEL MOUNTING CLIP
4	10-2143	HEX HEAD CAP SCREW, 5/16- 18 X 1-1/4"
5	10-2405	WASHER, 5/16"
6	10-2307	NUT, 5/16- 18
7	91-1958	FEATURE STRIP, 48", TILTING KETTLE
8	90-3154	DOOR ASSEMBLY, RIGHT HAND, STAINLESS STEEL
9	90-2993	DOOR ASSEMBLY, LEFT HAND, STAINLESS STEEL
10	10-0453	DOOR HINGE, LEFT BOTTOM
11	10-0454	DOOR HINGE, RIGHT BOTTOM
12	10-1869	SCREW, 10-32 X 1/2" FLAT HEAD
13	10-2545	HEX NUT & LOCKWASHER, 10/32"
14	90-2661	SIDE PANEL, STAINLESS STEEL
15	90-3210	BRACKET, MAGNETIC CATCH
16	10-1722	MACHINE SCREW, 6/32 X 3/8", ROUND HEAD
17	10-5561	MAGNETIC CATCH
18	10-2337	NUT, 6/32"
19	90-2657	REAR PANEL, STAINLESS STEEL
20	90-9057	DOOR HANDLE
21	10-0636	LEG, ADJUSTABLE, w/FLANGE (IF REQUIRED)
22	10-2511	LOCKWASHER, 5/16"
23	10-2515	LOCKWASHER, #6

Form No. S-2110 08/03
Printed in U.S.A.

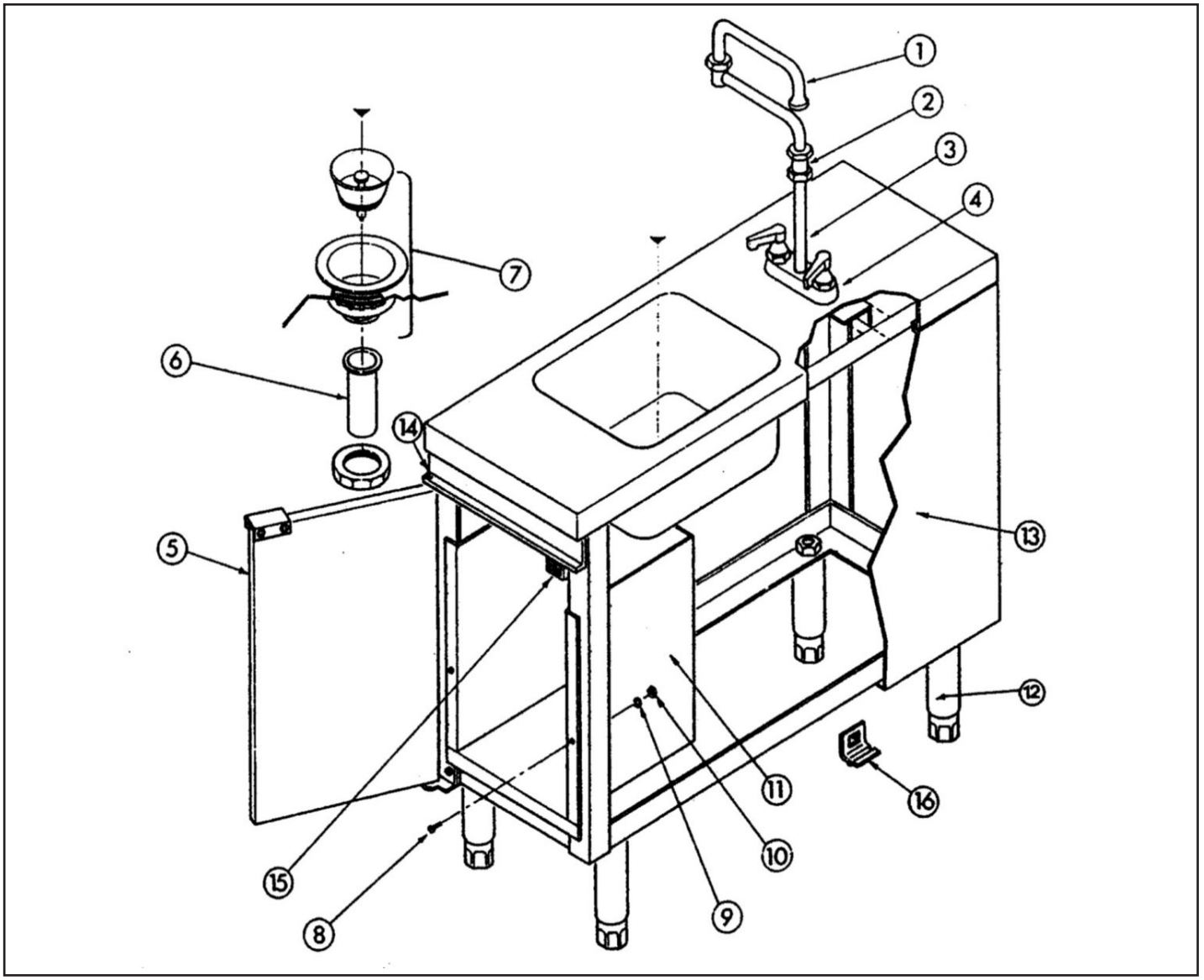
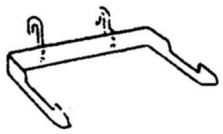
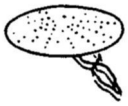
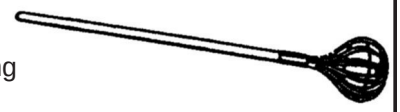
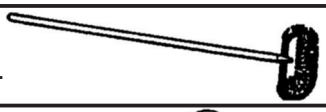


figure 4-21 21" SPACER WITH SINK & FAUCET

fig. 4-21 index no.	part no.	description
1	10-1316	SWIVEL SPOUT
2	10-1100	SWIVEL BODY
3	10-3767	RISER
4	10-5921	FAUCET
5	90-1714	DOOR ASSEMBLY, STAINLESS STEEL
6	10-1328	TAIL PIECE
7	10-0520	BASKET STRAINER, WASTE
8	10-1739	SCREW, MACHINE, TRUSS HEAD
9	10-2518	LOCKWASHER
10	10-2330	NUT
11	91-1917	BASE LINER ASSEMBLY
12	10-0631	LEG, ADJUSTABLE
13	90-2661	SIDE PANEL, STAINLESS STEEL
14	10-6417	FEATURE STRIP, (SEE FIG. 4-20)
15	10-5561	MAGNETIC LATCH
16	90-2663	PANEL MOUNTING CLIP

Form No. S-2110 08/03
Printed in U.S.A.

figure 4-22 ACCESSORIES FOR STEAM JACKETED KETTLES

NAME description	part no.
STATIONARY KETTLE KIT A convenience accessory package for use with Market Forge stationary steam jacketed kettles containing a stationary pan holder, solid disc, kettle paddle, 48" whip, 36" brush, clean-up brush, and 26" draw-off valve brush. (See item detailbelow)	90-4300
TILTING KETTLE KIT A convenience accessory package for use with Market Forge tilting steam jacketed kettles (except 5-gal. capacity) containing a solid disc, kettle paddle, 48" whip, 36" brush, clean-up brush and 26" draw-off valve brush. (See itemdetail below.)	90-4350
STATIONARY PAN HOLDER Holds standard cafeteria size pans (12" x 20") (1/1) at the kettle edge for easy filling. Ouickly attached ..... easily removed. Fits most 25 and 40 gallon 95 and 150 *litre* kettles. 	90-3427
PERFORATED STRAINER Prevents larger food particles from entering draw-off channel at the bottom of the kettle. Fits most 25 and 40 gallon 95 and 150 *litre* kettles. Standard with kettle. 	90-2305
SOIID DISC Prevents most solids or liquids from entering the draw-off at the bottom of most 25 and 40 gallon 95 and 150 *litre* kettles.	90-2306
KETTLE PADDLE A long-handled aluminum paddle allowing convenient access to the entire contents of the kettle when folding and mixing such food items as stews or bulky sauces.	10-5322
KETTLE WHIP 48" *1220mm* A long-handled, lightweight, stainless steel kettle whip for use in mixing ard blending puddings, sauces, soups, etc. 	10-5335
KETTLE BRUSH 36" *910mm* A long handled, tough, firm, nylon bristle brush for use in kettle cleaning. 	10-5308
CLEAN-UP BRUSH A sturdily constructed all-nylon bristle 'Bong' brush with water-resistant, crack-proof block.	10-5309
KETTLE DRAW-OFF VALVE BRUSH 26" *660mm* A handy, nylon bristle brush for use in cleaning the draw-off valve.	10-4995